

CLASSIFICATIONS

EN ISO 2560-A : E 46 5 B 42 H5

AWS A5.1 : E 7018 - 1 H4

DESCRIPTION

- Suitability for use in out-of-position welding except for welding at vertical down position
- High ductility at low temperatures down to -50°C
- Suitability for use in welding low-purity and high-carbon steels
- Weld deposits with very low hydrogen content
- High-quality weld metals with higher strength values
- Requirement of re-drying for minimum 2 hours at the temperatures between 300°C and 350°C

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.08 | Si: 0.4 | Mn: 1.4

MECHANICAL PROPERTIES

Yield Strength (MPa)	Tensile Strength (MPa)	Impact Strength (ISO-V/-50°C)	Elongation (L _o =5d _o) (%)
min. 460	530 - 650	min. 47 J	min. 24

BASE MATERIALS

- S235JR-E295, E335, S235J2G3-S355J2G3, P235T1-P355T1, P235T2, P355T2, L210NB-L415NB, L290MB-L360MB, P235G1TH, P255G1TH, P235GH-P355GH, S235JRS1-S235J45, S315G1 S-S355G3S, S255N-S380N, P255NH-P355NH, S255NL-S460NL1, GE200-GE300
- API 5L: X42, X46, X52, X56, X60, X65

WELDING POSITIONS



CURRENT CONDITION

D.C. (+)

OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
2010800118	2.50 x 350	3/32 x 14"	80 - 100	2200
2010800119	3.20 x 350	1/8 x 14"	100 - 140	3550
2010800120	4.00 x 450	5/32 x 18"	130 - 190	6570
2010800121	5.00 x 450	3/16 x 18"	190 - 240	10220