



<b>Standards:</b> EN 499	E - 42 3 B 42 H10
DIN 1913	E 51 54 B H10
AWS/ASME SFA - 5.1	E 7018 - H8
ISO 2560	E 423 B 42 H 10

**Application / Properties:** Electrode for producing crack-free and tough welding joints. Weld metal recovery is approx. 115%. Smooth and clean welds blending into base metal without undercut. Good gap bridging properties. Welds are X-ray quality. Suitable for depositing layers on steels having higher carbon content (up to 0.4) Owing to its double covering (up to 3.25 mm), the electrode shows a stable and concentrate arc.

**Weld metal analysis in % (typical values):**

C	Mn	Si	S	P
0.07	1.10	0.50	<0/02	<0/02

**Mechanical Properties of all -weld metal:**

(Single values are typical values)

Tensile Strength (N/mm <sup>2</sup> )	Yield Strength (N/mm <sup>2</sup> )	Elongation A5 (%)	Impact energy (J) ISO - V + 20 °C    - 30 °C	
500-610	>420	>22	150	70



**Welding Parameters**

	2.5	3.25	4.0	5.0	6.0
<b>Diameter (mm)</b>	2.5	3.25	4.0	5.0	6.0
<b>Length (mm)</b>	350	450	450	450	450
<b>Amperage(A)</b>	65-90	100-140	140-190	190-250	260-340



**Materials:**

<b>DIN Standard</b>	St 37-2 to St 60-2; St 37-3 to St 52-3 ; St 37.0 to St 52.0; St 37.4 to St52.4; StE 210.7 to StE 360.7; StE 210.7 TM to StE 360.7 TM; St 35.8 to St 45.8; H1; H11;17mn4; GL-A 36 to GL-E 36; STE 255 to StE 355 ; WStE 255 to WStE 355 ; TSIE 255 to TSIE 355 ; TT ST 35 N ; GS-38 ; GS-52. S235JRTtoE335; S235J2G3 to S355J2G3; P235T1toP355T1; P235T2; P355T2; L210 to L360NB; L290MB to L360MB; P235G1TH; P255G1TH; P235GH; P265GH; P295GH; S355G1S to S355G3S; S255N to S355N; P255NHtoP355NH; S255NL to S355NL .
<b>EN Standard</b>	
<b>ASTM Standard</b>	A27 a. A36 Gr. all; A214; A 242 Gr. 1-5; A266 Gr. 1, 2, 4; A283 Gr. A, B, C, D; A285 Gr. A, B, C; A299 Gr. A, B; A328; A366; A515 Gr. 60, 65, 70; A516 Gr. 55; A570 Gr. 30, 33, 36, 40, 45; A 572 Gr. 42, 50; A606 Gr. all; A607 Gr. 45; A656 Gr. 50, 60; A668 Gr. A, B; A907 Gr. 30, 33, 36, 40; A841; A851 Gr. 1, 2; A935 Gr. 45; A936 Gr. 50 API 5 L Gr. B, X42 - X56

**Redrying:** required at 300°C to 350°C for 2hrs.