

Standards :

TS EN ISO 2560-A	: E 42 2 Mo C 25
EN ISO 2560-A	: E 42 2 Mo C 25
AWS A5.5	: E 7010 - G

Chemical Composition of Weld Metal-
% (Typical) :

C	Si	Mn	Mo
0,10	0,15	0,4	0,4

Mechanical Properties :

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-20°C)	Elongation (L _o =5d _o)(%)
min, 420	510-590	min, 47 J	min, 22

Typical Base Material Grades :

* S235JR, S275JR, S235J2G3, S275J2G3, S355J2G3, P235GH, P265GH, P355T1, P235T2-P355T2, L210-L415NB, L290MB-L415MB, S235JRS1-S235J4S, P235G1TH, P255G1TH, X42-X65
Kök paso için L485MB, X70'e kadar.

Features and Applications :

- * Suitable for use in welding large-diameter pipelines made of high-strength steels as well as in all positions root-pass welding or surfacing of boilers and steel constructions
- * Deep penetration, especially (obtained) at vertical-down position

Welding Positions :



Current Type :

D.C. (+)

Operating Data :

Diameter x Length (mm)	Diameter x Length (inch)	Welding Current (A)	Weight g /100 pcs
2.50 x 350	3/32 x 14"	40 - 80	1620
3.20 x 350	1/8 x 14"	65 - 125	2650
4.00 x 350	5/32 x 14"	90 - 175	4040
5.00 x 350	3/16 x 14"	140 - 220	6210

Approvals :

TSE, CE