

Standards

TS EN ISO 3581-A	: E 29 9 R 12
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AWS A5.4	: ~E 312-16

Chemical Composition of Weld Metal % (Typical)

C	Si	Mn	Ni	Cr
0.12	1.0	0.8	10.5	30.0

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation (L ₀ =5d ₀) (%)
min. 490	700-830	min. 24 J	min. 20

Typical Base Material Grades

DIN: X7Cr13	G-X7Cr13	AISI: 403
X7CrAl13	G-X20Cr14	405
X10CrAl13	G-X10CrMo13	410
X8Cr17	G-X8CrNi13	420
X20Cr13		430
X15Cr13		430Ti
X22CrNi 17		431
X15CrNi13 4		446
X8CrTi17		

Features and Applications

- Alloyed-unalloyed high-resistant steels, Cr and Mn steels, joint welding of tool steels and different steels and repair welding of sprockets and wheelshaft
- Weld metal is resistant to corrossions, cracks and rust
- Requirement of re-drying for min. 2 hours at the temperatures between 120°C and 200°C

Welding Positions



Current Type

D.C.(+) / A.C.

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101208	2.50 x 250	3/32 x 10"	50 - 80	1260
3010101213	3.20 x 300	1/8 x 1 2"	80 - 110	2470
3010101218	3.20 x 350	1/8 x 14"	80 - 110	2890
3010101223	4.00 x 350	5/32 x 14"	110 - 160	4470

Approvals: TSE, CE, ABS, BV, SEPRO