

International standards	EN 499	E 42 0 RC 11
	AWS A 5.1	E6013

**Approvals** ---

**Typical applications  
and characteristics**

**Operating temperature** From +/- 0 up to + 350 °C

**Base materials**

DIN EN 10025	S235JRG1, S235JRG2, S235JRG3, S275JR, S275J2G3, S355J2G3
DIN EN 10028-2	P235GH, P265GH, P295GH, P355GH
DIN EN 10028-3	P275N, P355N, P275NH, P355NH
DIN 17100	St 37-2, St 44-2, St 52-3
DIN 17175	St 35.8, St 45.8, 17 Mn 4, 19 Mn 5
DIN 17102	StE 255 – StE 355
DIN 17172	StE 210. 7 – StE 360.7 TM
DIN 17155	H I, HII, 17 Mn 4, 19 Mn 6

**Mechanical properties  
of all-weld metal  
( typical values )**

Tensile strength $R_m$ N/mm <sup>2</sup>	Yield strength $R_{eL}$ N/mm <sup>2</sup>	Elongation $A_5$ %	Impact energy ISO – V J +/- 0° C
510	> 420	> 22	> 47

**Weld metal analysis  
(typical, wt %)**

C	Si	Mn
0.08	0.4	0.5

**Current** = - / ~ 42 V

**Welding positions** PA, PB, PC, PD, PE, PF. PG

**Rebaking** 1 h, 100 °C + / - 10 °C ( if necessary )

**Dimensions Current intensity No. of pieces/net weights** (typical values)

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	Kg/1000 pcs.	Kg/packet	Kg/carton
2,5 x 350	60 - 100	260	1040	19,2	5,0	20,0
3,2 x 350	90 - 140	166	664	30,1	5,0	20,0
4,0 x 350	140 - 180	105	420	47,6	5,0	20,0

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