

## Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.1	AWS A5.1M
E 35 0 A 1 2	E 4320 A	E6020	E4320

## Characteristics and typical fields of application

Very easy slag release; fine droplet metaltransfer; easy handling when making concave fillet welds. Also suitable for cutting applications; the C-content of the materials to be welded should not exceed 0.22 %.

## Base materials

S235JRG2 – S355J2; boiler steels P235GH, P265GH; GS-38, GS-45, St 35, St 45

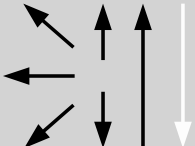
## Typical analysis of all-weld metal (wt.-%)

	C	Si	Mn
wt-%	0.09	0.15	0.50

## Mechanical properties of all-weld metal

Heat-treatment	Yield strength $R_{p0.2}$	Tensile strength $R_m$	Elongation A ( $L_0=5d_0$ )	Impact work ISO-V KV J
	MPa	MPa	%	+20 °C
aw	360	460	22	60

## Operating data

	<b>Polarity:</b> DC ( – ) / AC	<b>ø (mm)</b> 3.2	<b>L mm</b> 450	<b>Amps A</b> 110 – 160
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## Approvals

TÜV (01589), DB (10.132.01), CE