

**Standards :** \_\_\_\_\_

**Chemical Composition of Weld Metal-  
% (Typical) :**

TS EN 757	: E 55 6 Z B 42 H5
EN 757	: E 55 6 Z B 42 H5
AWS A5.5	: E 9018 - MH4R

C	Si	Mn	Ni	Mo
0.05	0.3	1.1	1.4	0.35

**Mechanical Properties :** \_\_\_\_\_

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (ISO-V/-60°C)	Elongation (L <sub>0</sub> =5d <sub>0</sub> )(%)	Heat Treatment
min. 550	620-780	80 J	min. 24	AW

**Typical Base Material Grades :** \_\_\_\_\_

- \* S380N-S500N, S355NH-S460NH, S380NL-500NL
- \* Fine grained, high alloyed steels and steel castings

**Features and Applications :** \_\_\_\_\_

- \* High resistance to cracking.
- \* Low amounts of Hydrogen (4 ml / 100 g).
- \* Operability at temperatures between - 60 °C and + 350 °C. \* Low content of moisture absorbed during long-term storage.

**Welding Positions :** \_\_\_\_\_



**Current Type :** \_\_\_\_\_

D.C.(+)

**Operating Data :** \_\_\_\_\_

Diameter x Length (mm)	Diameter x Length (inch)	Welding Current (A)	Weight g /100 pcs
3.20 x 350	1/8 x 14"	100 - 140	3640
4.00 x 450	5/32 x 18"	130 - 190	6730
5.00 x 450	3/16 x 18"	190 - 240	10130

**Approvals :** \_\_\_\_\_