

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

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

TS EN ISO 2560-A	:	E 46 8 3 Ni B
EN ISO 2560-A	:	E 46 8 3 Ni B
AWS A5.5	:	E 8018 - C2

C	Si	Mn	Ni
0.05	0.3	0.7	3.2

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

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (ISO-V/-100°C)	Elongation (Lo=5d <sub>0</sub> )(%)	Heat Treatment
min, 460	550-700	min, 47 J	min, 24	605 °C / 2h / 300 °C (air)

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

\* Cold-tough steels: 10 Ni14, 16Ni16, S 255NL1-S500NL1, S275NL2-P460NL2

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

\* Suitability for use in welding Ni-alloyed construction steels for cryogenic applications

\* High ductility and crack resistance in weld deposits

\* Serviceability of weld metals at temperatures down to -100 °C

\* Weld metal recovery of approx. 120%

\* Convenience of welding at all positions except for vertical down position

\* Weld deposits with very low contents of hydrogen

\* Requirement of re-drying for minimum 2 hours at the temperatures between 350 and 400 °C

**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"	70 - 100	2220
3.20 x 350	1/8 x 14"	110 - 140	3650
4.00 x 350	5/32 x 14"	140 - 180	6600
4.00 x 450	5/32 x 18"	190 - 230	8250

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

TSE