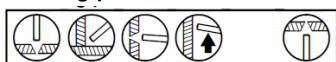




Date: 2020-03-18
Revision: 15



	C	Si	Mn	P	S	Cr	Ni
Min		0.40	1,10				
Typical	0,05	0,5	1,4	0,015	0,010		
Max	0,09	0,75	1,60	0,020	0,020	0,1	0,2

	Mo	Cu	V	Nb
Min				
Typical				
Max	0,1	0,2	0,05	0,05

Diam.mm	Length mm	Current A	Voltage V	Kg weld metal/ kg electrodes	No. of electrodes/ kg weld metal	Kg weld metal/ hour arc time	Burn-off time/ electrode (sec.)
2,0	300	40-80	23	0,64	112	0,7	43
2,5	350	70-110	23	0,69	62	0,9	58
3,2	450	80-145	24	0,71	30	1,3	85
4,0	450	120-210	25	0,73	20	1,8	90
5,0	450	200-285	25	0,75	13	2,7	93

$$N \leq 0.008\%$$

ITW Welding reserves the right to change specifications or approvals without prior notice.