



**Mild and Low Alloyed Consumables
REVOROD(GTAW) and REVOFIL(GMAW, SAW)**

Product	EN440/12070 /12534 AWS A5.18/5.28	Applications and Characteristics	Base Materials	Typical Chemical Analysis %		Mechanical Properties		EI %	Charpy Value (J)	
				Tensile Strength MPa	Yield Strength MPa	RT				
70S2	G2Ti ER70S-2	For joining and surfacing of mild steel.	S255N-P355N, P235GH-P265GH, P295GH, P355GH	C Si Mn Al Ti Zr	0.03 0.55 1.20 0.10 0.10 0.07	≥560	≥480	≥22	≥100	
70S3	G2Si1 ER70S-3	For joining and surfacing of mild steel.	S185-S275JR, S355JO-E335, S255N-P355N, P235GH-P265GH, P310GH	C Si Mn	0.09 0.60 1.15	≥500	≥420	≥22	≥80	
70S6	G3Si1 ER70S-6	For joining and surfacing of mild steel.	S185-S275JR, S355JO-E335, S255N-P355N, P235GH-P265GH, P310GH	C Si Mn	0.09 0.87 1.47	≥500	≥420	≥22	≥80	-50°C ≥47
70S6HT	G4Si1 ER70S-6	For joining and surfacing of mild steel.	S185-S275JR, S355JO-E335, S255N-P355N, P235GH-P265GH, P310GH	C Si Mn	0.09 0.95 1.67	≥530	≥460	≥22	≥80	-20°C ≥47
1NiMo	~Mn3Ni1Mo ER100S-G	For welding of high strength fine grain structural steels. Yield strength to 690MPa. For Yield strength >620 MPa only suitable for plate thickness up to 15mm and fillet weld.	S690QL1, S420N-S500N, P420NH-P500NH, S420NL-S500NL	C Si Mn Ni Mo	0.08 0.57 1.76 1.00 0.39	≥710	≥640	≥18	≥100	-40°C ≥47
1NiMo(SR)	ER100S-G	For welding fine grain low temperatures steels where impact values are required. In both as welded and PWHT condition	AISI 4130	C Si Mn Ni Mo	0.09 0.75 1.60 0.6 0.25	≥770 PWHT: 695	≥680 635°C x 2h 590	≥24 26	≥80	-60°C ≥47
1NiCrMo	Mn3Ni1CrMo ER110S-G	For welding of high strength fine grain structural steels. Yield strength to 690MPa	S690QL1, S420N-S500N, P420NH-P500NH, S420NL-S500NL	C Si Mn Cr Ni Mo V	0.09 0.52 1.57 0.30 1.40 0.25 0.09	≥790	≥690	≥16	≥80	-40°C ≥47
2NiCrMo	Mn4Ni2CrMo ER120S-G	For welding high strength fine grain structural steels.	S890QL	C Si Mn Cr Ni Mo	0.09 0.80 1.80 0.31 2.20 0.55	≥940	≥885	≥14	≥70	-60°C ≥47



**Low Temperature Consumables
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Product	EN440/12070 /12534 Material No. AWS 5.18/5.28	Applications and Characteristics	Base Materials	Typical Chemical Analysis %		Mechanical Properties		EI %	Charpy Value (J)	
				Tensile Strength MPa	Yield Strength MPa	RT	RT			
80SG	ZMn3Ni1Cu ER80S-G	For welding of weather resistant fine grain structural steels.	S235JRW- S355J2G1W, 9CrNiCuP3-2-4	C Si Mn Ni Cu	0.08 0.80 1.40 0.81 0.40	≥550	≥450	≥22	≥80	-40°C ≥47
80S-Ni1	G3Ni1 ER80S-Ni1	For welding of fine grain low temperature steels. Application down to -60°C.	P355NL1- P460NL1	C Si Mn Ni	0.09 0.51 1.05 0.95	≥560	≥470	≥24		-60°C ≥47
80S-Ni2	G2Ni2 ER80S-Ni2	For welding of fine grain low temperature steels. Application down to -60°C.	S255N-S380N, 14Ni6, 12Ni14, S255NL	C Si Mn Ni	0.09 0.51 1.12 2.42	≥570	≥420	≥22	≥100	-60°C ≥47
ENi3	A5.23 ENi3 A5.28	For welding fine grain low temperatures steels where high impact values are required	12Ni14	C Si Mn Ni	0.09 0.17 1.05 3.20	≥550	≥460	≥22	≥130	-80°C ≥47

**Heat Resistance Consumables
REVOROD(GTAW) and REVOFIL(GMAW, SAW)**

Product	EN440/12070 /12534 Material No. AWS 5.18/5.28	Applications and Characteristics	Base Materials	Typical Chemical Analysis %		Mechanical Properties		EI %	Charpy Value (J)	
				Tensile Strength MPa	Yield Strength MPa	RT	RT			
70SA1	G2Mo/G MoSi 1.5424 ER70S-A1	For elevated temperatures. For service temperature up to 500°C.	S235JRW, S355J2G1W, 9CrNiCuP3-2-4	C Si Mn Mo	0.10 0.60 1.15 0.51	≥560	≥460	≥22	≥60	-20°C ≥47
80S-D2	G4Mo ER80S-D2	For elevated temperatures. For service temperature up to 500°C.	P235G1TH- P255G1TH, P310GH, 16Mo3	C Si Mn Mo	0.09 0.70 1.95 0.50	≥550	≥470	≥17	≥90	-29°C ≥47
CrMo1	G CrMo1Si 1.7339 ER80S-G	For elevated temperatures. For service temperature up to 500°C. X-Factors ≤ 15ppm	13CrMo4-5	C Si Mn Cr Mo	0.10 0.60 1.00 1.20 0.52	≥450	≥300	≥20	≥100	-10°C ≥47
CrMo2	G CrMo2Si ER90S-G	For elevated temperatures service, application up to 600°C	10CrMo9-10, 10CrSiMoV7	C Si Mn Cr Mo	0.09 0.60 0.93 2.49 1.00	≥540	≥355	≥22	≥80	
80S-B2	ER80S-B2	For elevated temperatures service. Application up to 500°C, X-Factors ≤ 15ppm	13CrMo4-5	C Si Mn Cr Mo	0.09 0.55 0.56 1.28 0.52	≥550	≥470	≥19		
90S-B3	ER90S-B3	For elevated temperatures service. Application up to 600°C.	10CrMo9-10	C Si Mn Cr Mo	0.09 0.55 0.56 2.35 1.08	≥620	≥540	≥17		