

## Technical Datasheet

**For Welding Electrode XUPER 680 CGS (New product name: Welding Electrode Wunder 680), Dia: 2.5 mm, length - 350 mm.**

Tensile strength Rm:	770-850 Mpa
Yield strength Rp0.2:	>640 Mpa
Hardness (as welded):	240-280 HV30
Deposit density:	~7.6 g/cm <sup>3</sup>
Effective yield RE:	<110 %
Linear expansion I:	~13.5 x 10 <sup>-6</sup> (20-300°C)
Welding Current: AC/DC	45-85 Amp.
Length:	350mm