

Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.1-04	AWS A5.1M-04
E 42 0 RC 1 1	E 4313 A	E6013	E4313

Characteristics and typical fields of application

Rutile cellulose covered electrode.

General purpose; useable in all positions; excellent gap-bridging and arc-striking ability; for tack-welding and bad fit-ups. Well suited for welding rusty and primed plates (roughly 40 µm); excellent vertical down characteristics. Useable on small transformers (42 V, open circuit).

Base materials

TÜV approved base materials.

S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB

Shipbuilding steels; fine grained structural steels; weld able ribbed reinforcing steel bars.

ASTM A36 and A53 Gr. all; A106 Gr. A, B, C; A135 Gr. A, B; A283 Gr. A, B, C, D; A366; A285 Gr. A, B, C; A500 Gr. A, B, C; A570 Gr. 30, 33, 36, 40, 45; A607 Gr. 45; A668 Gr. A, B; A907 Gr. 30, 33, 36, 40; A935 Gr. 45; A936 Gr. 50; API 5 L Gr. B, X42-X52

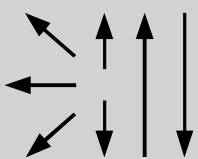
Typical analysis of all-weld metal

	C	Si	Mn
wt.-%	0.09	0.35	0.50

Mechanical properties of all-weld metal (min. values)

Heat-treatment	Yield strength R _{p0.2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J
	MPa	MPa	%	+20 °C
aw	420	510	22	50

Operating data

	Polarity	Ø mm	L mm	Amps A
	DC (-)	2.0	250	50 – 60
	AC	2.5	250	60 – 90
		2.5	350	60 – 90
		3.2	350	90 – 140
		4.0	350	150 – 190
		4.0	450	150 – 190
		5.0	350	190 – 240
		5.0	450	190 – 240

Approvals

TÜV (00425), DB (10.132.19), ABS, BV, LR, GL, DNV, CE