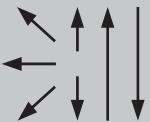


Stick electrode, unalloyed, rutile-cellulosic

Classifications				
EN ISO 2560-A		AWS A5.1		
E 42 0 RC 1 1		E6013		
Characteristics and typical fields of application				
Rutile cellulose covered electrode. General purpose; useable in all positions; excellent gap-bridging and arc-striking ability; for tackwelding 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				
S235JRG2 - S355J2; ship building steels				
Typical analysis of all-weld metal (wt.-%)				
C	Mn	Si		
0.08	0.50	0.20		
Mechanical properties of all-weld metal – typical values (minimum values)				
Heat-treatment	Yield strength R <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J
	MPa	MPa	%	20°C
u	> 420	> 510	> 22	> 80
u: untreated, as welded				
Operating data				
	Ø (mm)	Polarity	L mm	Amps A
	2.5	DC (–) AC	350	80 - 110
	3.2		350	110 - 130
4.0	350		140 - 160	
Approvals				
TÜV (01784) • DB (10.132.43) • BV • DNV • GL • LR • CE				