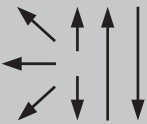


Classifications					
EN ISO 2560-A		AWS A5.1			
E 42 0 RC 1 1		E6013			
Characteristics and typical fields of application					
Useable in all positions for several applications like ship building, pipeline welding and steel constructions. Particularly suitable for constructional welding due to good welding characteristics in all positions without changing parameters. High mechanical values, crack resistant welds. Stable arc, easy striking. Smooth, easy modelling weld bead.					
Base materials					
S235JRG2 - S355J2; Ship building steels.					
Typical analysis of all-weld metal (wt.-%)					
C	Mn	Si			
0.08	0.45	0.35			
Mechanical properties of all-weld metal – typical values (minimum 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	
u	> 420	> 480	> 22	> 80	
Operating data					
	Ø (mm)	Polarity:	L mm	Amps A	Voltage V
	3.2	DC (-)	350	100 - 125	x - x
	4.0	AC	350	135 - 160	23 - 28
	4.5		350	155 - 180	
Approvals					
TÜV (00232) • CE					