

## 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).

## Grundwerkstoffe

S235JRG2 - S355J2; GS-38; GS-45; St35; St45; St35.8;

boiler steels P235GH, P265GH, P295GH; shipbuilding steels corresp. to app.-grade 2; fine grained structural steels up to P355N; weldable 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

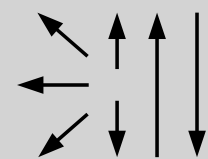
## Typical analysis of all-weld metal (wt.-%)

	C	Si	Mn
wt-%	0.09	0.35	0.50

## Mechanische Güterwerte des Schweißgutes

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
aw	420	510	22	50

## Operating data

	<b>Polarity</b>	<b>ø (mm)</b>	<b>L mm</b>	<b>Amps A</b>
	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