Rutile WE 6013

EN ISO 2560-A :	**E 38 0 R 12**	AWS A 5.1 :	**E 6013**	EN 499 :	**E 38 0 R 12**

DESCRIPTION AND USAGE:

Medium coated rutile electrodes specially designed for welding light metallic constructions and thin sheets from mild steels. Developed for welding of unalloyed steels with maximum 0,25% C content, for steel used down to 0°C , like:

- S235JR-S355JR, S235JO-S355JO, P195TR1
- P265TR1, P195GH-P265GH, L245NB-L360NB, L245MBL360MB, shipbuilding steels grade: A, B, D
- ASTM A 106 Gr. A, B; A 283 Gr. A, C; A 285 Gr. A, B, C; A 501 Gr. B; A 573 Gr. 58, 65; A 633 Gr. A, C;A 711 Gr. 1013
- API 5 L Gr. B, X42, X52

CHEMICAL COMPOSITION OF WELD METAL:

C %	Mn %	Si %	P %	S %
max. 0,09	0,30-0,70	0,20-0,50	max. 0,03	max. 0,03

MECHANICAL PROPERTIES OF WELD METAL :

Yield strength	Tensile strength	Elongation A 5d	Impact Energy Kv J	
N/mm²	N/mm²	%	+ 20 °C	0 °C
430-470	490-550	min. 24	min. 70	min. 47

WELDING BEHAVIOUR :

Very easy striking and restriking. The welding arc is stable, melting is in fine drops, with very low spatters. Slag is very easy to remove.

WELDING AND PACKAGING DATA :

DIAMETER	LENGTH	WELDING CURRENT	Kg/BOX
mm	mm	A	Kg
2,5	[300] 350	60 - 80	5,00
3,25	[350] 450	110 - 135	5,00
4,0	[350] 450	160 - 180	5,00
5,0	450	180 - 210	5,00

Welds in DC- or AC current with minimum 50V open circuit voltage.

WELDING POSITIONS :