

Universal rutile electrode, designed for welding in any position, including vertical down welding. It is easy to ignite and offers an excellent weldbead aesthetics. It is recommended for general construction of non-alloy and low alloy steel.

■ Classification

EN ISO 2560-A : E 42 0 RC 1 1
AWS A 5.1 : E6013

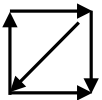
■ Applications

- * Metal constructions,
- * Tanks,
- * Pipework,
- * Metalwork,
- * Crafts

■ Benefits

- ✓ Easy ignition and re-ignition.
- ✓ Good weldability in all positions.
- ✓ Flat weld bead (slightly rounded) and easy cleanup.
- ✓ Excellent weldbead aesthetics.

■ Positions and polarity



- * Ignition from 40V - Direct current.
- * Electrode polarity (-).

■ Chemical properties

C %	Mn %	Si %	P %	S %
0.06	0.50	0.40	0.025	0.025

■ Mechanical properties

Re	Rm	A 5 d	KV 0 °C
440 MPa	540 MPa	24%	50 J

■ Recommendations

Ø électrode (mm)	1.6	2.0	2.5	3.2	4.0
thickness (mm)		1,5 ▶ 3	2,5 ▶ 6	5 ▶ 8	8 ▶ +
welding current (A)	30	40 ▶ 70	60 ▶ 100	80 ▶ 130	130 ▶ 170

■ Approval

TÜV - DB



Packaging

	Ref.	Ø (mm)	length (mm)	parts / packaging	weight / case (Kg)	cases / parcels
A	084315	Ø 1.6	350	17	0.16	
	084414		350	50	0.41	
	084322		350	13	0.22	
	084421	Ø 2.0	350	50	0.71	
	084339		350	11	0.24	
	084438		350	50	1.00	
	084346	Ø 3.2	350	9	0.30	
	084445		350	50	1.50	
	084353		350	8	0.38	
B	084452	Ø 4.0	350	50	2.24	
	085114		300	210	1.65	6
	085121		350	155	2.08	6
	085138	Ø 2.5	350	110	2.11	6
	085145		350	70	2.09	6
	085152		350	47	2.21	6
	085022	Ø 2.0	350	355	4.82	3
	085039		350	230	4.46	3
	085046		350	165	4.85	3
C	085053	Ø 4.0	350	110	5.39	3
	086005		350	252	4.6	1
	086012		350	172	5	1
	086029	Ø 4.0	350	117	5	1
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