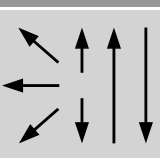


Classification						
EN ISO 2560-A	EN ISO 2560-B	AWS A5.1	AWS A5.1M			
E 38 0 RC 1 1	E 4313 A	E6013	E4313			
Characteristics and typical fields of application						
Rutile-cellulosic electrode with good weldability in all positions including vertical-down. Viscous puddle, good gap bridging ability, easy handling. For industry and trade, assembly and shop welding.						
Base materials						
Steels up to a yield strength of 380 MPa (52 ksi) S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, ship building steels: A, B, D, A 32, A 36, D 32, D 36 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						
Typical analysis of all-weld metal (wt.-%)						
	C	Si	Mn			
wt.-%	0.06	0.4	0.5			
Mechanical properties of all-weld metal						
Condition	Yield strength R _e	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J		
	MPa	MPa	%	+20 °C	±0 °C	-10 °C
u	430 (≥ 380)	490 (470 – 600)	26 (≥ 20)	75	60 (≥ 47)	58
u untreated, as welded						
Operating data						
	Polarity:	Redrying:	Electrode identification:	ø (mm)	L mm	Amps A
	DC (-)	not necessary	FOX MSU 6013	2.5	250	70 – 100
	AC		E 38 0 RC	3.2	350	90 – 130
				4.0	350	140 – 180
Approvals						
TÜV (1104.), DB (10.014.01), SEPROZ, CE						