

## Classifications

EN ISO 2560-A	EN ISO 2560-B:	AWS A5.1	AWS A5.1M
E 38 2 RB 12	E4303 A U	E6013 (mod.)	E4313 (mod.)

## Characteristics and typical fields of application

Rutile-basic electrode especially recommended for out-of-position work except vertical-down. Excellently suited for welding root passes. Produces first class X-ray quality welds. Excellent welding properties on A.C. Preferably used in structural and tank welding as well as in tube & pipe construction. High mechanical properties, thus suitable for many different base metals.

## Base materials

Steels up to a yield strength of 380 MPa (52 ksi)

S235JR-S355JR, S235JO-S355JO, S275N-S355N, S275M-S355M, P235GH-P355GH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB

ASTM A 106 Gr. A, B; A 283 Gr. A, C; A 285 Gr. A, B, C; A 414 Gr. A, B, D, G; A 501 Gr. B; A 516 Gr. 55, 60, 65, 70; A 573 Gr. 58, 65, 70; A 588 Gr. A, B; A 633 Gr. A, C, D; A 662 Gr. A, B, C; A 711, Gr. 1013; API 5 L Gr. B, X42, X52

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

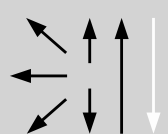
	C	Si	Mn
wt.-%	0.08	0.2	0.45

## Mechanical properties of all-weld metal

Condition	Yield strength R <sub>e</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J			
				+20 °C	±0 °C	-10 °C	-20 °C
u	<b>420</b> (≥ 380)	<b>500</b> (470 – 600)	<b>28</b> (≥ 20)	<b>90</b>	<b>75</b>	<b>70</b>	<b>60</b> (≥ 47)

u untreated, as welded

## Operating data

	<b>Polarity:</b> DC (-) AC	<b>Redrying:</b> not necessary	<b>Electrode identification:</b> FOX SPE E 38 2 RB	ø (mm)	L mm	Amps A
				2.0	250	45 – 75
				2.5	250/350	60 – 100
				3.2	350	90 – 140
				4.0	450	110 – 190
				5.0	450	170 – 250

## Approvals

TÜV (0731.), DB (10.014.03), LTSS, SEPPOZ, CE