

## Classifications

EN ISO 2560-A	EN ISO 2560-B:	AWS A5.1	AWS A5.1M
E 38 0 RR 12	E4313 A	E6013	E4313

## Characteristics and typical fields of application

Rutile coated electrode with extraordinarily good weld ability in all positions except vertical-down. Excellent welding properties on A.C., good striking and restriking characteristics.

Soft arc, minimum spattering, very easy slag removal, famous for fine rippled and smooth weld surfaces.

## Base materials

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

S275JR, S235J0G3 - S355J0G3, P235GH, P265GH, P255NH, P235T1, P355T1, P235T2-P355T2, P235G1TH, P255G1TH, L210 - L360NB, L290MB, S235JRS1 - S235J0S1, S235JRS2 - S235J0S2  
ASTM A36 u A53 Gr. alle; A106 Gr. A, B, C A 135 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.-%	0.07	0.3	0.5

## 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		
	MPa	MPa	%	+20 °C	±0 °C	-10 °C
u	<b>430</b> (≥ 380)	<b>500</b> (470 – 600)	<b>26</b> (≥ 20)	<b>75</b>	<b>60</b> (≥ 47)	≥ 32

u untreated, as welded

## Operating data

	Polarity:	Redrying:	Electrode identification:	ø (mm)	L mm	Amps A
	DC (-)	not necessary	FOX SUM 6013	2.5	250	60 – 100
	AC		E 38 0 RR	3.2	350	90 – 130
				4.0	350	110 – 170