

Classifications

| EN ISO 2560-A | EN ISO 2560-B: | AWS A5.1 | AWS A5.1M |
|---------------|----------------|----------|-----------|
| E 42 0 RR 12 | E4313 A | E6013 | E4313 |

Characteristics and typical fields of application

Rutile electrode with excellent weld ability in all positions except vertical-down, even under the most unfavourable conditions.

Distinguished by excellent restriking characteristics, minimum spattering and excellent welding properties on A.C. The weld seam is characterised by fine rippled and smooth beads, the slag is self-detaching.

Base materials

Steels up to a yield strength of 420 MPa (60 Ksi)

S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, L415NB, L415MB,

ship building steels: A, B, D,(A 32, A 36, D 32, D 36 - nur BV)

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, 70; A 633, Gr. A, C; A 711 Gr. 1013; API 5 L Gr. B, X42, X52, X60

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

| | C | Si | Mn |
|-------|------|-----|-----|
| wt.-% | 0.07 | 0.5 | 0.6 |

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 (≥ 420) | 510 (500 – 640) | 27 (≥ 20) | 75 | 55 (≥ 47) | 45 |

u untreated, as welded

Operating data

|  | Polarity: DC (-) AC | Redrying: not necessary | Electrode identification: FOX SUS 6013 E 42 0 RR | ø (mm) | L mm | Amps A |
|---|------------------------------------|-----------------------------------|---|--------|---------|-----------|
| | | | | 2.0 | 300 | 60 – 80 |
| | | | | 2.5 | 350 | 80 – 100 |
| | | | | 3.2 | 350/450 | 120 – 150 |
| | | | | 4.0 | 450 | 160 – 200 |
| | | | | 5.0 | 450 | 220 – 250 |

Approvals

TÜV (1657.), DB (10.014.69), ABS (2), BV (2Y), DNV (2), GL (2), LR (X), SEPPOZ, CE