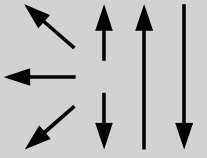


| Classifications | | | | | | |
|--|-------------------|--------------------------|------------|-----------------|-----------|--------|
| EN ISO 2560-A | | | AWS A5.1 | | | |
| E38 0 RC 11 | | | E6013 | | | |
| Characteristics and field of use | | | | | | |
| Rutile cellulose coated stick electrode with very good weldability in all positions, including vertical down. | | | | | | |
| Universal electrode, particularly for small transformers. Bendable covering. Versatile application in steel, vehicle, boiler, container and ship construction, as well as for galvanised components. | | | | | | |
| Base materials | | | | | | |
| Steels up to a yield strength of 380 MPa (52 ksi) | | | | | | |
| S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MBL360MB, shipbuilding steels: A, B, D | | | | | | |
| 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 in % | | | | | | |
| C | | Si | | Mn | | |
| 0,06 | | 0,4 | | 0,45 | | |
| Mechanical properties of the weld metal | | | | | | |
| Heat-treatment | Yield strength | Tensile strength | Elongation | Impact strength | | |
| | R _{PO,2} | R _m | A | K _V | 0 °C | -10 °C |
| | MPa | MPa | % | J | 0 °C | -10 °C |
| untreated | 430 | 490 | 25 | 75 | 60 | 47 |
| | ≥ 380 | 470 – 600 | ≥ 20 | | ≥ 47 | |
| Welding positions | | | | | | |
|  | | Current type DC (-) / AC | | | | |
| Approvals | | | | | | |
| TÜV (5687.), DB (10.014.12), ABS (2), DNV (2), LR (2), LTSS, SEPROZ, CE | | | | | | |
| Recommended welding parameters | | | | | | |
| Electrodes Ø x L [mm] | 2,0 x 250 | 2,5 x 250/350 | 3,2 x 350 | 4,0 x 350/450 | 5,0 x 450 | |
| Amperage [A] | 45 – 80 | 60 – 100 | 90 – 130 | 110 – 170 | 170 – 240 | |