

E 'Manual metal-arc welding'
ESAB-MÓR Kft Hungary

Prepared by A-C Thorsson	Qualified by Tero Borg	Approved by J-P Ernoult	Reg no EN007044	Cancelling EN006747	Reg date 2016-02-11	Page 1 (2)
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REASON FOR ISSUE

Typical mechanical values added.

GENERAL

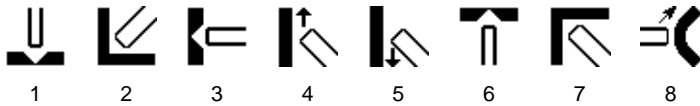
General purpose rutile all-positional electrode with particularly satisfying results in the overhead welding of fillet welds, lap joints and sealing runs.

Min AC OCV: 50 V

Coating Type: Rutile

Polarity: AC, DC-(+)

WELDING POSITIONS



CLASSIFICATIONS Electrode

SFA/AWS A5.1 E6013
EN ISO 2560-A E 42 0 RC 11

APPROVALS

ABS 2
BV 2
CE EN 13479
DB 10.105.06
DNV 2
GL 2Y
LR 2
VdTÜV 03086

APPROVALS (SPECIFIC)

RS 2

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C	0.05	0.11
Si	0.30	0.70
Mn	0.40	0.80
P		0.030
S		0.030
Cr		0.19
Ni		0.29
Mo		0.19
V		0.049
Nb		0.049
Cu		0.29

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MECHANICAL PROPERTIES OF WELD METAL

Properties	AWS	ISO		
	As welded Min	As welded Min	Max	Typ
Rp0.2 (MPa)	330			
ReL (MPa)		420		450
Rm (MPa)	430	510	640	520
A4 (%)	17			
A5 (%)		22		26
Charpy V at 0°C (J)		47		60
	Comments:	Comments: EN standard requires Rm min 500 MPa and A5 min 20%.		

ECONOMICS & CURRENT DATA

Dimension (mm) Ø x Length	Current (A)		W	η	N	B	H	T	U	Welding Positions
	Min	Max								
2.5 x 350	60	90	1.8	94	0.62	91	0.8	49	25	1,2,3,4,5,6,7,8
3.2 x 350	90	140	2.9	93	0.59	59	1.1	57	24	1,2,3,4,5,6,7,8
4.0 x 350	110	185	4.4	88	0.58	40	1.4	64	26	1,2,3,4,5,6,7,8

W = Weight (kg / 100 electrodes)

η = Efficiency (g weld metal x 100 / g core wire)

N = Effective value (kg weld metal / kg electrodes)

B = Changes (number of electrodes / kg weld metal)

H = Deposit rate at 90% of max current (kg weld metal / hour arc time)

T = Fusion time at 90% of max current (s / electrode)

U = Arc voltage (V)