Standards

TS EN ISO 2560-A	: E 42 0 RR 12
EN ISO 2560-A	: E 42 0 RR 12
AWS A5.1	: E 6013

Chemical Composition of Weld Metal % (Typical)

C	Si	Mn
0.07	0.3	0.5

Mechanical Properties

Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/0°C)	Elongation ($L_o=5d_o$) (%)
min. 420	510-610	min. 47 J	min.22

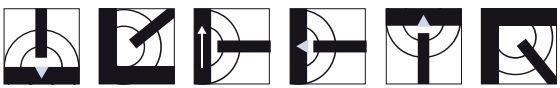
Typical Base Material Grades

- S 235JR, S275JR, S235J2G3-S355J2G3, P235 GH, P265 GH, P255NH, P235T1-P355T1, P235T2-P355T2, P235G1TH, P255G1TH, L210-L360NB, S235JRS1-S235J2S1, S235JRS2 - S235J2S2

Features and Applications

- The mostly-used type among the rutile electrodes
- Electrode coating of high thickness
- Spatter and fume formation in low amounts
- Good welding beads
- Easy striking

Welding Positions



Current Type

D.C.(-) / A.C.

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100003	2.00 x 300	5/64 x 12”	45 - 80	1160
3010100012	2.50 x 350	3/32 x 14”	60 - 110	2000
3010100018	3.20 x 350	1/8 x 14”	100 - 140	3220
3010100024	4.00 x 350	5/32 x 14”	140 - 180	4740
3010100027	4.00 x 450	5/32 x 18”	140 - 180	6220
3010100030	5.00 x 350	3/16 x 14”	170- 240	7640
3010100033	5.00 x 450	3/16 x 18”	170 - 240	9680

Approvals: TSE, CE, TL, DNV-GL, BV, ABS, LR, NK, RINA, TÜV, DB, SEPRO, CWB