

CATEGORY	SMAW Stick Electrodes	
TYPE	Rutile cellulosic electrode for welding in all positions	
APPLICATIONS	This electrode is specially developed for maintenance and repair in shipbuilding and ship repair as also for similar jobs and or bad prepared seams in other constructions.	
PROPERTIES	The weld puddle is amazingly fast freezing and therefore especially preferred in vertical down position with high speed and deep penetration. Due to the wood powder based coating the weld puddle is super fast freezing and therefore amazing results can be achieved on old and dirty or otherwise diluted plates.	
CLASSIFICATION	AWS EN ISO F-nr FM	A 5.1: E 6013 2560-A: E 42 0 RC 11 2 1

SUITABLE FOR

Steel type:	DIN:	W.Nr.:
Unalloyed steels:	St 33 to St 52.3	1.0035 to 1.0570
Boiler plates:	H1, H11, 17 Mn4	1.0345, 1.0425, 1.0481
Pipe steels:	St 35 to St 52.4	1.0308 to 1.0581
-	StE 210.7 to StE 360.7	1.0307 to 1.0582
Shipbuilding plates:	A, B, D	1.0440, 1.0472, 1.0475
Steel castings:	GS-38 to GS-52	1.0416 to 1.0551
Thin sheets:	1623/1	-

APPROVALS	CE
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WELDING POSITIONS:



TYPICAL WELD DEPOSIT WEIGHT %

C	Si	Mn	P	S
0.08	0.4	0.6	0.02	0.02

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V 0°C
As Welded /	450	560	22	67

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING	PACKING
D (MM)	LENGTH (MM)	CURRENT (A) DC+/-/AC	KG / CAN	KG / 6PACK	KG / 1000
2,5	350	55-85	2.4	14.4	14.9
3.2	350	90-140	2.6	15.6	34.4
4.0	350	130-180	2.6	15.6	44.9
5.0	350	180-230	2.8	16.8	89.6

REDRYING TEMPERATURE	140°C / 1 hr
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GAS ACCORDING EN 14175	
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