

RUTILE ELECTRODE

CLASSIFICATION

AWS A5.1: E6013

ISO 2560-A: E 38 0 R 11

GENERAL DESCRIPTION

Rutile general purpose, all positions electrode.

Applicable for "clean" structural steel.

Smaller diameters excellent for hobby market.

Very suitable for low open circuit voltage transformers.

WELDING POSITIONS



ISO/ASME PA/1G



PB/2F



PC/2G



PF/3G up



PG/3G down



PE/4G



PF/5G up



PG/5G down

CURRENT TYPE

AC / DC electr.-

APPROVALS

ABS
2

BV
2

DNV
2

GL
2

LR
2

TÜV
+

CHEMICAL COMPOSITION (w%), typical all weld metal

C	Mn	Si
0,07	0,5	0,45

MECHANICAL PROPERTIES, ALL WELD METAL

	Condition	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation (%)	Impact ISO-V(J) 0°C
Required AWS A5.1		Min. 331	Min. 414	Min. 17	Not required
ISO 2560-A		Min. 380	470-600	Min. 20	Min. 47
Typical values	AW	430	500	26	60

PACKAGING, AVAILABLE SIZES AND IDENTIFICATION

	Diameter (mm)	2.0	2.5	3.2	3.2	4.0	4.0	5.0
	Length (mm)	300	350	350	450	350	450	450
Unit : box	Pieces/unit (nominal)	370	250	175	150	110	95	55
	Net weight/unit (kg)	4.2	4.8	5.3	6.2	5.0	5.9	5.8

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