

OK 43.32



Easy-to-weld rutile type electrode for welding in the flat position. The good flowing properties of the weld metal give a good finish to the weld beads on both butt and fillet welds. Good slag detachability. The stable arc, even at low welding currents, makes the electrode very suitable for sheet metal welding.

Classifications:	SFA/AWS A5.1:E6013, EN ISO 2560-A:E 42 0 RR 12
Approvals:	CE EN 13479, ABS 2, DNV 2, BV 1, GL 1, RS 2, DB 10.039.36, LR 1, VdTÜV 00621

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current:	AC, DC+-
Alloy Type:	Carbon Steel
Coating Type:	Rutile

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As welded	460 MPa	520 MPa	27 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As welded	0 °C	60 J
As welded	-10 °C	55 J

Typical Weld Metal Analysis %

C	Mn	Si
0.07	0.5	0.4

Deposition Data

Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
2.0 x 300 mm	50-60 A	23 V	0.54	167	36 s	0.6 kg/h
2.5 x 350 mm	50-110 A	25 V	0.54	88	46 s	0.9 kg/h
3.2 x 350 mm	80-150 A	26 V	0.57	51	57 s	1.3 kg/h
3.2 x 450 mm	80-140 A	26 V	0.54	40.5	74 s	1.3 kg/h
4.0 x 350 mm	120-210 A	25 V	0.52	35	63 s	1.6 kg/h
4.0 x 450 mm	120-210 A	27 V	0.54	27	76 s	1.9 kg/h
5.0 x 450 mm	170-290 A	26 V	0.56	17	87 s	2.5 kg/h
6.0 x 450 mm	230-370 A	30,6 V	0,52	12,4	105 s	2,8 kg/h