

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 ₀ =5d ₀)(%)
min. 420	510-610	min. 47 J	min. 22

Typical Base Material Grades :

* S 235JR,S275JR, S235J2G3-S355J2G3, P235 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 :

Diameter x Length (mm)	Diameter x Length (inch)	Welding Current (A)	Weight g /100 pcs
2.00 x 300	5/64 x 12``	45 - 80	1050
2.50 x 350	3/32 x 14``	60 - 110	2050
3.20 x 350	1/8 x 14``	100 - 140	3250
4.00 x 350	5/32 x 14``	140 - 180	4820
4.00 x 450	5/32 x 18``	140 - 180	6185
5.00 x 350	3/16 x 14``	170 - 240	7700
5.00 x 450	3/16 x 18``	170 - 240	9945

Approvals :

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