

Standards :

TS EN ISO 2560-A	:	E 38 2 RB 12
EN ISO 2560-A	:	E 38 2 RB 12
AWS A5.1	:	~E 6013

Chemical Composition of Weld Metal-
% (Typical) :

C	Si	Mn
0.08	0.2	0.5

Mechanical Properties :

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-20°C)	Elongation (L ₀ =5d ₀)(%)
min. 380	470-570	min. 47 J	min. 24

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 :

- * Electrode of rutile-basic character
- * Electrode coating with high thickness
- * Suitability for welding of pressure pipes
- * Smooth welding bead without under cuts

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
2.50 x 350	3/32 x 14"	60-110	1930
3.20 x 350	1/8 x 14"	90-140	3315
4.00 x 350	5/32 x 14"	110-200	4730
4.00 x 450	5/32 x 18"	110-200	6075

Approvals :

TSE, CE, GOST-R, SEPRO