

RUTWELD 2 EXTRA

Electrodes MMA [SMAW]

Construction, unalloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 2560-A : E 42 0 RR 12 DIN 1913 : E 51 22 RR 6 AWS A-5.1 : E 6013	UDT	Constructions & Engineering Metallurgy (Steelworks) Mining Petrochemical and chemical industry Light construction and hobby

- Thick coated electrode for welding mild and low alloyed steels in such elements as structures, boilers, etc., in fillet weld.
- High welding speed, no spatter, minimal welding fumes.
- In fillet welds, it guarantees easy slag removal and perfect weld appearance.
- Polarity (-) is recommended for thin-walled profiles and polarity (+) for thick structures.
- It can be welded with 230 V welding machines. Recommended for welding with devices with the VRD system (with reduced no-load voltage to approx. 18 V).

Recommendations:

- Do not exceed the range of proper currents - welding with too high current causes an increase in the number of spatters, the formation of undercuts and insufficient coverage of the weld with slag.
- Do not overdry - excessive drying prior to use causes a decrease in penetration depth and overheating of the electrode.

Application

Steel structures: trusses, portal frames, tubular frames. Sheet metal constructions and container sheathing, storage tanks, hoppers, silos. Light steel frames - grills, furniture, gates, decorations. Welding of agricultural equipment. General workshop welding and maintenance. Welding all types of mild (low carbon) steel.


Base material

	EN
Construction steels:	S235-S355
Boiler plates:	P235-P355
Pipe steels:	P235, P275, P295, P355
Shipbuilding plates:	A, B, D

Typical chemical composition %

C	Si	Mn
0,08	0,50	0,60

Typical mechanical properties

Yield strength Re [N/mm ²]	>420
Tensile strength Rm [N/mm ²]	500-640
Elongation A5 [%]	>20
Impact energy Kv [J]	>47J (0°C) /
Coating type	rutile
Welding current	

Welding positions**Redrying**

140°C / 1h

Welding parameters and packing

∅	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]	Pcs/1 kg
2,0	300 /	50-70	2,4	14,4	90
2,5	350 /	55-85	4,5	13,5	51
3,2	350 /	90-135	4,0	12,0	31
4,0	450 /	130-170	5,5	16,5	15
5,0	450 /	175-220	5,5	16,5	9

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