

RUTWELD BS

Electrodes MMA [SMAW]

Construction, unalloyed steels

CLASSIFICATION: EN ISO 2560-A : E 38 2 RB 12 DIN 1913 : E 43 43 RR(B) 7 AWS A-5.1 : E 6013	APPROVALS: UDT	APPLICATION: Power generation industry Constructions & Engineering Metallurgy (Steelworks) Mining Petrochemical and chemical industry Shipbuilding&Offshore Light construction and hobby
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- Rutile basic electrode for welding mild steel and low alloyed steels.
- It guarantees good mechanical and welding properties.
- Recommended for root pass welding of pressure pipelines.
- When performing professional work (especially on pipelines), only DC is used.
- Particularly recommended for welds in the PF position.

Application

Tanks, dynamically and statically loaded structures (ship structures, rolling stock, construction machinery, gas and pressure pipelines).



Base material

	EN
Construction steels:	S235-S275
Boiler plates:	P235GH-P275GH
Pipe steels:	P235-P295
Shipbuilding plates:	A, B, D

Typical chemical composition %

C	Si	Mn
0,10	0,20	0,50

Typical mechanical properties

Yield strength Re [N/mm²]	>380
Tensile strength Rm [N/mm²]	470-600
Elongation A5 [%]	>20
Impact energy Kv [J]	>47J (0°C) /
Coating type	rutile-basic
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 /	55-70	1,0	12,0	94
2,5	350 /	70-90	4,5	13,5	50
3,2	350 /	115-145	5,6	16,8	30
4,0	450 /	145-190	6,0	18,0	15

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