

RUTWELD Z

Electrodes MMA [SMAW]

Construction, unalloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 2560-A : E 42 0 RC 11 DIN 1913 : E 51 22 RR(C) 6 AWS A-5.1 : E 6013	UDT	Constructions & Engineering Metallurgy (Steelworks) Mining Petrochemical and chemical industry Shipbuilding&Offshore Agriculture Light construction and hobby

- Thick coated rutile-cellulose electrode.
- For repairing and maintenance works (e.g. in shipbuilding and construction).
- Very good welding properties in all positions, including hard-to-weld positions.
- Good weldability when welding dirty material (rust, paint, grease).
- Very good penetration.
- Creates a flat joint with a smooth face.
- Especially recommended for welding galvanized sheets: the zinc is rolled up before the weld, so less pollutants get into the air, increasing the safety of the welder.

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 constructions: trusses, portal frames, tubular frames. Sheet metal constructions and container sheathing, storage tanks, hoppers, silos. Connection of pipes for the transmission of various media in the field. 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
Galvanizing plates	

Typical chemical composition %

C	Si	Mn
0,08	0,40	0,60

Typical mechanical properties

Yield strength Re [N/mm2]	>420
Tensile strength Rm [N/mm2]	500-640
Elongation A5 [%]	>20
Impact energy Kv [J]	>47] (0°C) /

Coating type	rutile-cellulosic
Welding current	 U₀ < 50V
Welding positions	
Redrying	140°C / 1h
Remarks	PG position only for diameter 2,5 and 3,2 mm.

Welding parameters and packing

∅	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]	Pcs/1 kg
2,0	300 /	30-50	2,1	12,6	90
2,5	350 /	55-85	4,0	12,0	51
3,2	350 /	90-135	4,0	12,0	31
4,0	350 /	130-170	4,0/4,5	12,0/13,5	20

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