

RUTWELD 12

Electrodes MMA [SMAW]

Construction, unalloyed steels

CLASSIFICATION: EN ISO 2560-A : E 38 0 RC 11 DIN 1913 : E 43 22 R(C)3 AWS A-5.1 : E 6012/E 6013	APPROVALS: UDT TDT: E 38 0 RC 21	APPLICATION: Constructions & Engineering Metallurgy (Steelworks) Mining Agriculture Light construction and hobby
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- A medium coated rutile-cellulose electrode recommended for welding in all positions, for assembly and workshop use, for universal usage.
- Excellent primary and secondary ignition.
- Flexible, stable electric arc, easy to operate in hard-to-weld positions, easy slag removal, does no need to require high welding experience.
- It can be welded with small 230 V hobby welding machines.
- An electrode for everyday use, for simple constructions, also for unexperienced welders.

Application

Metal containers and tanks, light constructions, small machines and devices as well as steel tools.

Base material

	EN
Construction steels:	S235-S275
Boiler plates:	P235GH-P275GH
Pipe steels:	L235-L295
Shipbuilding plates:	A, B, D

Typical chemical composition %

C	Si	Mn
0,08	0,30	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]	>47] (0°C) /
Coating type	rutile-cellulosic
Welding current	U ₀ < 50V
Welding positions	
Redrying	110°C / 1h

Welding parameters and packing

∅	Length [mm]	Welding	Weight of	Weight of	Pcs/1 kg
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		current [A]	packet [kg]	carton [kg]	
1,6	250 /	30-50	2,0	12,0	192-196
2,0	300 /	50-70	2,5	15,0	105-106
2,5	350 /	55-85	5,0	15,0	55-56
3,2	350 /	90-140	5,0	15,0	34
4,0	350 / 450 /	130-180	5,0/6,0	15,0/18,0	22/17
5,0	450 /	180-230	6,0	18,0	10

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