



Selectarc 51

Universal Rutile Electrode

Classification

AWS A5.1 : E6013
 EN 499 : E 42 0 RC 1 1
 ISO 2560-A : E 42 0 RC 1 1

Description & Applications

Universal all position mild steel electrode. Good operability and easy slag removal. Suitable for current supplies with low open arc voltage.

Main applications: In metal constructions, for piping systems, tanks, blacksmithing, craft works.

Base materials

Construction steels for general use , Tube steels, Ship steels

EN- Designation	S185 – S355 P235 – P355	L210 – L360
Ship steels	Quality A and B	
ASTM	A285 grade C A442 grade 55, 60	A414 grade C, D, E, F A515 grade 55, 60, 65

Typical Weld Metal Composition (%)

C	Si	Mn	P	S	Fe
<0.10	0.4	0.45	<0.025	<0.025	Rem.

All Weld Metal Mechanical Properties

R_e (MPa)	R_m (MPa)	A_5 (%)	KV (J)
>420	510-580	>22	+20°C >65 0°C >47 -20°C >28

Welding Current & Instructions

Electrode	ØxL (mm)	1,6x300	2,0x300	2,5x350	3,2x350	3,2x450	4,0x350	4,0x450	5,0x450
Current	(A)	30	50	70	110	110	140	140	170

Ind.12



= - ~ 40V

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