



# Selectarc 55

*Rutile Electrode  
With a very thick coating*

## Classification

AWS A5.1 : E6013

EN 499 : E 42 0 RR 1 2

ISO 2560-A : E 42 0 RR 1 2

## Description & Applications

Thick coated rutile electrode destined for flat or for fillet welding when a nice aspect of the weld bead is searched. Concave bead on fillet welds, very soft fusion and a self releasing slag ; supports high current. Frequently used for final passes.

### Base materials

### Construction steels for general use , Tube steels, Ship steels

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

## Typical Weld Metal Composition ( % )

C	Si	Mn	P	S	Fe
<0.10	0.45	0.6	<0.025	<0.025	Rem.

## All Weld Metal Mechanical Properties

R <sub>e</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
>400	510-580	>22	+20°C >64 0°C >47 -20°C >28

## Welding Current & Instructions

Electrode	ØxL ( mm )	2,0x300	2,5x350	3,2x350	3,2x450	4,0x450	5,0x450
Current	( A )	70	90	135	135	180	250

ind.12



= -	~ 45V
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