



# Selectarc D6

Rutile Electrode  
Vertical down

## 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 rutile cellulosic electrode especially elaborated for welding in vertical down position. Good penetration, regular weld beads and a little bit convex in flat position, self releasing slag in vertical down position. Destined for general construction works where the majority of welds are effected in vertical down position, but also used as universal electrode.

**Main applications:** For metal constructions, blacksmithing and maintenance works, frame, piping...

### 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	0.6	<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 >70 0°C >50 -20°C >30

## Welding Current & Instructions

Electrode	ØxL ( mm )	2,0x300	2,5x350	3,2x350	4,0x350
Current	( A )	60	80	130	170

ind.12



= - ~ 40V

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