

## Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.1 / SFA-5.1	AWS A5.1M
E 42 0 R 1 2	E 4312 A	E6012	E4312

## Characteristics and typical fields of application

Rutile coated electrode for tank construction and structural engineering. Particularly suitable for welding thin sheets in all welding positions ( $\emptyset$  2.0/2.5 mm also in PG (3F) position).

Soft arc; low spatter; excellent striking and re-striking ability. Easy slag removal.

## Base materials

S235JRG2 - S355J2, weld able thin sheets

## Typical analysis

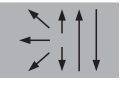
	C	Si	Mn
wt.-%	0.08	0.35	0.5

## Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength $R_{p0.2}$	Tensile strength $R_m$	Elongation A ( $L_0=5d_0$ )	Impact energy ISO-V KV J
	MPa	MPa	%	20°C
u	420	510	22	50

u untreated

## Operating data

	Polarity	DC (-) / AC	Dimension mm	Current A
	Electrode identification	FOX Green / E 42 0 R / E6012		2.5 × 350 3.2 × 350

## Approvals

DB (10.014.51), CE