

Classifications

EN ISO 3581-A

E Z 19 9 3 R 5 3

Characteristics and typical fields of application

Special electrode for welding of rule die steels. This electrode provides easy striking and re-striking, excellent welding characteristics as well as very ductile and crack resistant joints welds on rule die steel.

Base materials

Rule die steels

Typical analysis

	C	Si	Mn	Cr	Ni	Mo
wt.-%	0.07	0.7	0.55	19.7	9.1	2.8

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	-60°C
u	600 (≥ 400)	790 (≥ 620)	30 (≥ 25)	60	50 (≥ 32)

Operating data

	Polarity	DC+ / AC	Dimension mm	Current A
	Electrode identification	FOX RDA	1.5 × 250	40 – 60
			2.0 × 250	50 – 80

Preheating and interpass temperature as required by the base metal.

Suggested heat input is max. 1.5 kJ/mm .

Re-drying if necessary at 120 – 200°C for min. 2 h.

Approvals

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