

## Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.1	AWS A5.1M
E 42 2 RB 5 3	E 4928 A	E7028	E4928

## Characteristics and typical fields of application

Rutil basic covered high performance electrode with 160 % weld metal recovery. Easy slag removal; fine rippled smooth welds; particularly good welding characteristics on primer-coated plates. Among other applications useable for gravity and autocontact welding.

## Base materials

S235JRG2 - S355J2;  
Boiler steels P235GH/P265GH/P295GH;  
Fine grained structural steels up to P355N- and M-grades;  
Shipbuilding steels acc. A - E-grades, AH 32 to NVE 36

## Typical analysis of all-weld metal (wt.-%)

	C	Si	Mn
wt-%	0.08	0.30	0.85

## Mechanical properties of all-weld metal

Heat-treatment	Yield strength R <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J	
	MPa	MPa	%	+20 °C	-20 °C
aw	420	510	22	90	47
sr	400	470	27	85	47

## Operating data

	<b>Polarity:</b> DC ( + ) / DC ( - ) AC	<b>ø (mm)</b>	<b>L mm</b>	<b>Amps A</b>
		3.2	450	120 – 170
		4.0	450	180 – 230
		5.0	450	240 – 300
6.0	450	290 – 390		

## Approvals

TÜV (01700), DB (10.132.36) ABS, BV, GL, LR, DNV, DE