

Classifications

EN ISO 2560-A	EN ISO 2560-B:	AWS A5.1	AWS A5.1M
E 42 0 RR 12	E4313 A	E6013	E4313

Characteristics and typical fields of application

Rutile electrode with excellent weld ability in all positions except vertical-down, even under the most unfavourable conditions.

Distinguished by excellent restriking characteristics, minimum spattering and excellent welding properties on A.C. The weld seam is characterised by fine rippled and smooth beads, the slag is self-detaching.

Base materials

Steels up to a yield strength of 420 MPa (60 Ksi)

S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, L415NB, L415MB,

ship building steels: A, B, D,(A 32, A 36, D 32, D 36 - nur BV)

ASTM A 106, Gr. A, B; A 283 Gr. A, C; A 285 Gr. A, B, C; A 501, Gr. B; A 573, Gr. 58, 65, 70; A 633, Gr. A, C; A 711 Gr. 1013; API 5 L Gr. B, X42, X52, X60

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

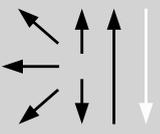
	C	Si	Mn
wt.-%	0.07	0.5	0.6

Mechanical properties of all-weld metal

Condition	Yield strength R _e	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J		
	MPa	MPa	%	+20 °C	±0 °C	-10 °C
u	430 (≥ 420)	510 (500 – 640)	27 (≥ 20)	75	55 (≥ 47)	45

u untreated, as welded

Operating data

	Polarity: DC (-) AC	Redrying: not necessary	Electrode identification: FOX SUS 6013 E 42 0 RR	ø (mm)	L mm	Amps A	
					2.0	300	60 – 80
					2.5	350	80 – 100
					3.2	350/450	120 – 150
					4.0	450	160 – 200
					5.0	450	220 – 250

Approvals

TÜV (1657.), DB (10.014.69), ABS (2), BV (2Y), DNV (2), GL (2), LR (X), SEPPOZ, CE