

**RUTWELD 2 EXTRA****CLASSIFICATION:**

EN ISO 2560-A: E 42 0 RR 12  
DIN 1913: E 51 22 RR 6  
AWS A-5.1: E 6013

**APPROVALS:**

UDT

**DESCRIPTION:**

- Thick coated electrode for welding mild and low alloyed steels in such elements as structures, boilers, etc., in fillet weld.
- High welding speed, no spatter, minimal welding fumes.
- In fillet welds, it guarantees easy slag removal and perfect weld appearance.
- Polarity (-) is recommended for thin-walled profiles and polarity (+) for thick structures.
- It can be welded with 230 V welding machines. Recommended for welding with devices with the VRD system (with reduced no-load voltage to approx. 18 V).

**APPLICATION:**

Steel structures: trusses, portal frames, tubular frames. Sheet metal constructions and container sheathing, storage tanks, hoppers, silos. Light steel frames - grills, furniture, gates, decorations. Welding of agricultural equipment. General workshop welding and maintenance. Welding all types of mild (low carbon) steel.

**BASE MATERIAL:**

	EN
Construction steels	S235-S355
Boiler plates	P235-P355
Pipe steels	P235, P275, P295, P355
Shipbuilding plates	A, B, D

**TYPICAL CHEMICAL COMPOSITION (%):**

C 0,08 Si 0,50 Mn 0,60

**TYPICAL MECHANICAL PROPERTIES:**

Re: >420 N/mm<sup>2</sup>  
Rm: 500-640 N/mm<sup>2</sup>  
A5: >20%  
Kv: >47J (0°C)

Coating: rutile  
Redrying: 140°C / 1 h



U<sub>0</sub> < 50V

Welding parameters			Packing		
φ	Length [mm]	Current [A]	Weight of packet [kg]	Weight of carton[kg]	Pcs/1 kg
2,0	300	50-70	2,4	14,4	90
2,5	350	55-85	4,0	12,0	51
3,2	350	90-135	4,0	12,0	31
4,0	450	130-170	5,5/6,0	16,5/18,0	15
5,0	450	175-220	5,5	16,5	9