RUTWELD 1 EXTRA

Electrodes MMA [SMAW]

Construction, unalloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 2560-A : E 42 0 RC 11 DIN 1913 : E 51 22 RR(C) 5 AWS A-5.1 : E 6013	UDT	Constructions & Engineering Metallurgy (Steelworks) Mining Petrochemical and chemical industry Agriculture Light construction and hobby

- Universal, thick coated electrode for welding mild unalloyed and low alloyed steels in all positions.
- Recommended for welding dirty and galvanized steel.
- Excellent welding properties in all positions, including vertical down, smooth arc and very fine beads, no spatters, self removal slag.
- It can be welded with small 230 V welding machines. Recommended for welding with devices with the VRD system (with reduced no-load voltage to approx. 18 V).
- Recommended for hobby welding.

Recommendations:

- Do not exceed the range of proper currents - welding with too high current causes an increase in the number of spatters, the formation of undercuts and insufficient coverage of the weld with slag.
- Do not overdry - excessive drying prior to use causes a decrease in penetration depth and overheating of the electrode.

Base material

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

Typical chemical composition %

C	Si	Mn
0,08	0,40	0,60

Typical mechanical properties

Yield strength Re [N/mm2]	>420
Tensile strength Rm [N/mm2]	500-640
Elongation A5 [%]	>20
Impact energy Kv [J]	>47J (0°C) /
Coating type	rutile-cellulosic
Welding current	

	
Welding positions	
Redrying	140°C / 1h
Remarks	PG position only for diameter 2,5 and 3,2 mm.

Welding parameters and packing

⌀	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]	Pcs/1 kg
2,0	300 /	50-60	2,3	13,8	93
2,5	350 /	55-85	4,5	13,5	51
3,2	350 /	90-140	4,5	13,5	31
4,0	350 /	130-180	4,5	13,5	22

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