

Rutile electrode - E13

EN ISO 2560-A: E 38 0 RC 11
DIN 1913 E43 22 R(C) 3
AWS A5.1: E 6013

This rutile electrode is intended for general applications for welding in all positions recommended for joining the elements of small and average thickness and edges with large gaps between them. It assures smooth face with easy removable slag. It is recommended for small transformer welding machines.

Approvals:

ABS*

LR*

BV*

* Certificate is pending

Coating:

Rutile

Drying:

100 - 120 °C/1h

Welding current:

~=(+/-)

Welding positions:



Product no

ø mm	2,0	2,5	3,25	4,0
Code	E13.095	E13.096	E13.097	E13.098

Typical Chemical composition of the weld metal (%)

C	Si	Mn
0,09	0,20	0,41

Typical mechanical properties of the weld metal

Test method	Condition	R _m MPa	R _{el} (R _{p0.2}) MPa	A ₅ /(A ₄) %	KV (J)/°C
ISO	TZ0	470 - 600	>380	>20	>47

TZ0 - after welding

Technological parameters

ø d	Length	Welding current	Arc voltage	Deposition efficiency	Melting time	Electrode deposition efficiency	pcs./kg od of weld metal	Weld metal efficiency
(mm)	(mm)	(A)	(V)	(%)	(s)			(kg/h)
2,0	300	35 - 50	22	148	77	0,50	150	0,31
2,5	350	50 - 80	25	89	59	0,60	94	0,65
3,2	450	80 - 130	22	93	79	0,63	42	1,08
4,0	450	120 - 180	22	90	85	0,62	29	1,47