Selectarc 51

Universal Rutile Electrode

Classification

AWS A5.1 : E6013 EN 499 : E 42 0 RC 1 1
ISO 2560-A : E 42 0 RC 1 1

Description & Applications

Universal all position mild steel electrode. Good operability and easy slag removal. Suitable for current supplies with low open arc voltage.

Main applications: In metal constructions, for piping systems, tanks, blacksmithing, craft works.

Base materials

Construction steels for general use , Tube steels, Ship steels

EN- Designation	S185 – S355	L210 – L360
	P235 – P355	
Ship steels	Quality A and B	
ASTM	A285 grade C	A414 grade C, D, E, F
	A442 grade 55, 60	A515 grade 55, 60, 65

Typical Weld Metal Composition (%)

C	Si	Mn	P	S	Fe
<0.10	0.4	0.45	<0.025	<0.025	Rem.

All Weld Metal Mechanical Properties

R_e (MPa)	R_m (MPa)	A_5 (%)	KV (J)
>420	510-580	>22	+20°C >65 0°C >47 -20°C >28

Welding Current & Instructions

Electrode	ØxL (mm)	1,6x300	2,0x300	2,5x350	3,2x350	3,2x450	4,0x350	4,0x450	5,0x450
Current	(A)	30	50	70	110	110	140	140	170

Ind.12



= -	~ 40V

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.