Selectarc 54

Rutile Electrode
Nice appearence

Classification

AWS A5.1 : E6013 EN 499 : E 42 0 RR 1 2
ISO 2560-A : E 42 0 RR 1 2

Description & Applications

Heavy coated rutile electrode for general use. Especially recommended for downhand welding, for fillet welds and vertical up position. Soft arc, few spatters, self lifting slag, excellent bead appearance.

Main applications: Currently used for welding mechanical constructions, shipbuilding, blacksmithing, boiler making...

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	0.6	<0.025	<0.025	Rem.

All Weld Metal Mechanical Properties

R_e (MPa)	R_m (MPa)	A_5 (%)	KV (J)
>400	510-580	>22	+20°C >64 0°C >47 -20°C >28

Welding Current & Instructions

Electrode	ØxL (mm)	2,0x300	2,5x350	3,2x350	3,2x450	4,0x350	4,0x450	5,0x450
Current	(A)	55	70	115	115	150	150	180

Ind.12



= -	~ 45V

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