Selectarc RR B7

Rutile-Basic Electrode
For root passes

Classification

AWS A5.1 : E6013
ISO 2560-A : E 38 2 RB 1 2

EN 499 : E 38 2 RB 1 2

Description & Applications

Special rutile-basic coated electrode to weld in all positions. Especially designed for welding root passes. Good operability, easy striking , strong arc with low spatters, good penetration and easy slag removal. Supports high current.

Main applications: Used in metal constructions, for piping systems, tanks, locksmithing, 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	0.3	0.6	<0.025	<0.025	Rem.

All Weld Metal Mechanical Properties

R_e (MPa)	R_m (MPa)	A_5 (%)	KV (J)
>430	470-600	>20	+20°C 95 -20°C 60

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x350	5,0x450
Current	(A)	70-90	100-140	140-180	200-260

ind.12

= -	~ 40V

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