



Product Data Sheet

OK 46.00

E 'Manual metal-arc welding'
ESAB-MÓR Kft Hungary

Signed by P-O Oskarsson	Approved by Rune Pedersen/Barbro Karlström	Reg no EN003413	Cancelling EN002931	Reg date 2006-06-15	Page 1 (2)
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REASON FOR ISSUE

Approvals updated, CE added. EN ISO 2560-A added

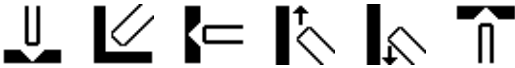
GENERAL

All-round, all-positional rutile electrode for thin and medium thick plates. Good striking and restriking properties, suitable for tack welding. Useful for bridging gaps.

Min AC OCV: 50
Polarity: AC, DC+-

Alloy Type: Carbon Manganese
Coating Type: Rutile

WELDING POSITIONS



CLASSIFICATIONS Electrode

SFA/AWS A5.1 E6013
EN ISO 2560-A E 38 0 RC 11

APPROVALS

ABS 2
BV 2
CE EN 13479
DB 10.039.05
DNV 2
GL 2
LR 2
RS 2
VdTÜV 00623

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C	0.05	0.12
Si	0.10	0.50
Mn	0.15	0.65
P		0.030
S		0.030



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MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal	
	Min	Typ
	ISO	
	As welded	
ReL (MPa)	380	400
Rm (MPa)	480	510
A4-A5 (%)	24	28
Charpy V at -0°C (J)	47	70
Charpy V at -20°C (J)	28	35
	Comments: Elongation ISO: A5%	

ECONOMICS & CURRENT DATA

Dimension (mm) Ø x Length	Current (A)		W	η	N	B	H	T	U
	Min	Max							
2.0 x 300	50	70	1	93	0.60	172	0.55	38	25
2.5 x 350	60	100	1.8	95	0.65	86.0	0.80	50	22
3.2 x 350	80	150	2.9	95	0.65	53.0	1.30	57	22
3.2 x 450	80	150	3.7	93	0.64	43	1.33	63	22
4.0 x 350	100	200	4.5	95	0.60	39.0	1.60	65	22
4.0 x 450	100	200	5.7	87	0.6	30	1.6	76	23
5.0 x 350	150	290	6.9	90	0.60	24.0	2.30	87	24

- W** = Weight (kg / 100 electrodes)
η = Efficiency (g weld metal x 100 / g core wire)
N = Effective value (kg weld metal / kg electrodes)
B = Changes (number of electrodes / kg weld metal)
H = Deposit rate at 90% of max current (kg weld metal / hour arc time)
T = Fusion time at 90% of max current (s / electrode)
U = Arc voltage (V)

OTHER DATA

Applications: Manual metal arc welding of carbon steels and carbon-manganese steels.