

Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.1	AWS A5.1M
E 42 0 RR 12	E 4313 A	E6013	E4313

Characteristics and typical fields of application

Rutile electrode offering top weld ability in all positions except vertical-down. Extremely smooth beads, self-detaching slag, minimum spattering and excellent welding properties on A.C. Excellent re-striking characteristics and easy handling. Good deposition lengths attainable. Versatile applications in trade and industry.

Base materials

Steels up to a yield strength of 420 MPa (60ksi)

S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, L415NB, L415MB, ship building steels: A, B, D

ASTM A 106, Gr. A, B; A 283 Gr. A, C; A 285 Gr. A, B, C; A 501, Gr. B; A 573, Gr. 58, 65, 70; A 633, Gr. A, C; A 711 Gr. 1013; API 5 L Gr. B, X42, X52, X60

Typical analysis of all-weld metal

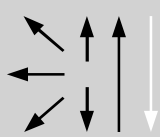
	C	Si	Mn
wt.-%	0.07	0.4	0.5

Mechanical properties of all-weld metal – typical values (min. values)

Condition	Yield strength R _e	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J	
	MPa	MPa	%	+20 °C	±0 °C
u	430 (≥ 420)	520 (≥ 500 – 640)	26 (≥ 20)	65	50 (≥ 47)

u untreated, as welded

Operating data

	Polarity: DC (–) / AC	Electrode identification: FOX ETI 6013 E 42 0 RR	ø mm	L mm	Amps A
			1.5	250	40 – 60
			2.0	250	45 – 80
			2.5	250/350	60 – 110
			3.2	350/450	90 – 140
			4.0	450	110 – 190
			5.0	450	170 – 240

Approvals

TÜV (1097.), ABS (2), BV (2), DNV (2), GL (2), LR (2m), LTSS, SEPPOZ, CE