Primafixe

Rutile-cellulosic stick electrode, unalloyed

Classifications

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

Characteristics and typical fields of application

Rutile-cellulosic coated electrode with good weld ability in all positions including vertical-down.
Easy handling, instantaneous striking and re-striking
Suitable for the most diverse applications for unalloyed steels.

Base materials

Steels up to a yield strength of 380 MPa (52 Ksi)
S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB. 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; A 633, Gr. A, C; A 711 Gr. 1013; API 5 L Gr. B, X42, X52

Typical analysis of all-weld metal

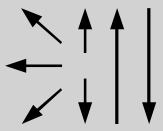
	C	Si	Mn
wt.-%	0.07	0.35	0.4

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

Condition	Yield strength $R_{p0,2}$	Tensile strength R_m	Elongation A (L_0=5d_0)	Impact work ISO-V KV J	
	MPa	MPa	%	0 °C	-10°C
u	**410** (≥ 380)	**500** (470 - 600)	**21** (≥ 20)	**60** (≥ 47)	47

u untreated, as welded

Operating data



Polarity:	ø mm	L mm	Amps A
DC (+/–) / AC	2.5	350	60 – 90
	3.2	350	90 – 130
	4.0	350	125 – 180

Approvals

TÜV (00404.), CE