



Classification : AWS A5.1 : E6013

EN 499 : E 42 0 RC 11

ISO 2560-A : E 42 0 RC 11

Properties and applications :

Universal electrode. Applications very varied in all positions, pleasant fusion and easy removal milkman. Perfect for the use of welding devices with very low voltage vacuum.

Applications: metal constructions, tanks, piping, handicrafts, locksmiths.

Weldable steel materials :

General use for steel constructions, steel pipes, maritime steel sheets		
Designation-EN	S185 - S355	L210 - L360
	P235 - P355	
Maritime sheets	Quality A et B	
ASTM	A285 grade C	A414 grade C, D, E, F
	A442 grade 55,60	A515 grade 55, 60, 65

Analyse of type of deposit steel(%) :

C	Si	Mn	P	S
<0.10	0.4	0.45	<0.025	<0.025

Mechanical characteristics of deposit steel

Re (MPa)	Rm (MPa)	A ₅ (%)	KV (J)
420	510-580	>22	+20° C > 65 -20° C > 47 -50° C > 28

Average intensity & Conditions of use :

Electrode	øxL (mm)	1,6x300	2,0x300	2,5x350	3,2x350	3,2x450	4,0x350	4,0x450	5,0x450
Intensity	(A)	30	50	70	110	110	140	140	170

Welding position

