elektrode jesenice d.o.o.

EMONA

Classification:

GOST 9467-60:	E 46-T
EN 499:	E 38 2 RB 12
DIN 1913:	E 43 43 RR(B)7
AWS A-5.1:	E 6013
EN ISO 2560-A:	E 38 2 RB 12
EN ISO 2560-B:	E 43 03 A

Description and application:

Thick basic-rutile coated electrode for welding low alloyed steels with tensile strength up to 510 N/mm2. The weld metal deposit has high mechanical properties and can be used for a wide range of materials.

Base materials:

	DIN:	W.Nr.:
Unalloyed steels:	St 33 to St 52.3	1.0035 to 1.0570
Boiler plates:	HI, HIII, 17Mn4	1.0345, 1.0435, 1.0481
Pipe steels:	St 35 to St 52.4	1.0308 to 1.0581
	StE 210.7 to StE 360.7	1.0307 to 1.0582
Shipbilding plates:	A, B, D, E	1.0440 to 1.0476
Steel castings:	GS-38 to GS-52	1.0416 to 1.0551
Finegrained steels	StE 255 to StE 355	1.0461 to 1.0562

Coating type:

Basic-rutile

Welding current:

AC
DC -

Welding positions:

Redrying temperature:

140°C / 1 h

Typical all weld metal properties:

Chemical composition, wt %:

C	Si	Mn
0.10	0.20	0.55

Mechanical properties:

Yield strength	R_{eL} / $Rp_{0.2}$:	> 380	MPa (N/mm^2)
Tensile strength	Rm:	470 - 600	MPa (N/mm^2)
Elongation	A5:	> 24	%
Impact energy	KV:	> 47	J (-20°C)

Approvals:

CR: 3
ABS: 3
BV: 3
GL: 3
LR: 3
DNV: 3
TÜV
SŽ

Welding and packing data:

Welding parameters			Packing		
ϕ mm	Length mm	Current A	Weight/ packet kg	Weight/ carton kg	Weight/ 1000 pcs kg *
2	300	55 – 70	4	20	11
2.5	300/350	70 – 90	4/4.4	20/22	17.1/19.5
3.25	350	115 – 145	4.4	22	32.8
4	450	145 – 190	5.4	27	62.5
5	450	200 – 250	5.4	27	98.4
6	450	250 - 290	5.4	27	142.9

* approximate data