

Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.1M	AWS A5.1 / SFA-5.1
E 42 0 RR 1 2	E4313 A	E4313	E6013

Characteristics and typical fields of application

Rutile coated electrode offering top weldability in all positions except vertical-down. Extremely smooth beads, self-detaching slag, minimum spattering and excellent welding properties on alternating current. 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, Schiffbaustähle: 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


	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 energy ISO-V KV J	
	MPa	MPa	%	20°C	0°C
u	430 (≥ 420)	520 ($\geq 500 - 640$)	28 (≥ 20)	65	55 (≥ 47)

u untreated, as welded

Operating data

	Polarity	DC - / AC	Dimension mm	Current A
	Electrode identification	FOX ETI 6013 E 42 0 RR		
			2.0 × 250	45 – 80
			2.5 × 250	60 – 110
			2.5 × 350	60 – 110
			3.2 × 350	90 – 140
			3.2 × 450	90 – 140
			4.0 × 450	110 – 190
			5.0 × 450	170 – 240

Approvals

TÜV (01097), DB (10.014.102/01), ABS, BV, DNV, LR, CE