

Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.1 / SFA-5.1	AWS A5.1M
E 42 0 RR 1 2	E 4313 A	E6013	E4313

Characteristics and typical fields of application

Rutile covered electrode. Minimum spatter formation, self releasing slag; finely rippled, smooth welds with notch-free weld metal / parent metal interface. Unproblematical welding of general-purpose structural steels; also suitable for vertical down welding in diam. up to 2.0 mm. Outstanding striking and restriking ability.

For use on small transformers (42 V, open circuit).

Base materials

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

S235JRG2 - S355J2; St 35; St 45; St 35.8; St 45.8;

boiler steels P235GH, P265GH, P295GH; shipbuilding steels; fine grained structural steels up to P355N- and M-grades.

ASTM A36 and A53 Gr. all; A106 Gr. A, B, C; A135 Gr. A, B; A283 Gr. A, B, C, D; A366;

A285 Gr. A, B, C; A500 Gr. A, B, C; A570 Gr. 30, 33, 36, 40, 45; A607 Gr. 45; A668 Gr. A, B;

A907 Gr. 30, 33, 36, 40; A935 Gr. 45; A936 Gr. 50;

API 5 L Gr. B, X42-X56

Typical analysis

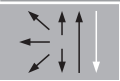
	C	Si	Mn
wt.-%	0.08	0.35	0.55

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 energy ISO-V KV J
	MPa	MPa	%	20°C
u	420	510	22	60

u untreated, as welded

Operating data

	Polarity	DC - / AC	Dimension mm	Current A
	Electrode identification	Phoenix Grün T / E 42 0 RR / E 6013		2.0 × 250
			2.5 × 350	60 - 100
			3.2 × 350	85 - 140
			3.2 × 450	85 - 140
			4.0 × 350	130 - 200
			4.0 × 450	130 - 200
			5.0 × 450	230 - 300
			6.0 × 450	280 - 370

Approvals

TÜV (00350), DB (10.014.52), ABS, BV, LR, DNV, CE