

Rutile Coated Electrode for Mild Steels

Classification

EN ISO 2560-A : E 42 0 RR 12
AWS A5.1 : E6013

General Description

AS R-143 is a heavily coated rutile electrode. As its basic component quantity is higher than AS R-116, weld metal properties are superior accordingly. Weld metal has a high resistance to cracking. The slag is easy to remove, and it gives high quality, smooth and excellent weld beads. It is easy to strike and re-strike and thus an ideal, easy to use electrode.

Chemical Composition (w%), Typical, All Weld Metal

C	Si	Mn
0.08	0.35	0.65

Mechanical Properties, Typical, All Weld Metal

Yield Strength	: 480 N/mm ²
Tensile Strength	: 550 N/mm ²
Elongation (L=5d)	: 25 %
Impact (ISO-V)	: 60 J (0°C) 40 J (-20°C)

Approvals

CE, DB, GOST, SEPRO, TSE, TÜV

ABS	BV	DNV	LRS	RINA	TL
2	2	2	2m	2	2

Welding Parameters / Packing and Diameter Informations / Welding Positions

Current Type and Polarity : AC min 50 V ; DC (-)

Diameter [mm]	Length [mm]	Current [A]	Electrode Weight [g/100 pcs]	Box Weight [kg] Quantity [pcs/box]	Export Box Box Weight [kg]
2.00	300	50 - 70	1050	2.1 / 195	2
2.50	350	65 - 90	2070	2.1 / 100	5
3.25	350	90 - 140	3230	3.2 / 100	5
4.00	350	140 - 200	4770	4.8 / 100	5
4.00	450	140 - 190	6690	6.7 / 100	6
5.00	350	180 - 240	7550	4.9 / 65	5
5.00	450	180 - 230	9910	6.4 / 65	6



1G/PA

2F/PB

2G/PC

4G/PE

3G/PF

Rutile Coated Electrode for Mild Steels

Applications and Materials to be Welded

AS R-143 is a general purpose electrode especially used for the welding of low and medium carbon structural steels ranging between St 33 and St 52.3. Machinery fabrications, bridge constructions; welding of boiler vessels, automotive bodies, steel furnitures, metal plate works, thin plates and small repairs are among its application areas.

	<u>DIN</u>	<u>EN</u>
General Structural Steels	St 33, St 34, St 37, St 44, St 44-2, St 44-3, St 52, St 52-3 St 37-4, St 44-4, St 52-4	S185, S235, S275, S355 P235TR2 - P355T2
Fine Grained Steels	StE 255 - StE 420 WStE 255	S255N - S420N P255NH
Pipe Materials	StE 210-7 - StE 360-7 StE 290-7 TM - StE 360-7 TM X42, X46, X52, X60 (API 5LX)	L210 - L360NB L290MB - L360MB -
Boiler and Pressure Vessel Steels	17 Mn 4, 19 Mn 6 HI, HII, HIII	P295GH, P355GH P235GH, P265GH, P285NH
Elevated Temperature Steels	St 35-8, St 45-8	P235G1TH - P255G1TH
Ship Plates	A, B, D AH32 - EH36	- -
Cast Steels	GS-38, GS-45, GS-52	GE200, GE240, GE260