

## Rutile Coated Electrode for Mild Steels

### Classification

EN ISO 2560-A : E 42 0 RC 11  
 AWS A5.1 : E6013

### General Description

AS R-145 is a rutile-cellulosic type coated electrode with medium recovery. It can be used in all positions including vertical downwards position. It is easy to bend electrode, this property brings great convenience to reach the welding groove in difficult-to-reach areas. Arc stability is high. Especially the thin sheets can be welded easily. It gives uniform and smooth weld beads with easy slag removal. It is very easy to strike and re-strike.

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

C	Si	Mn
0.07	0.35	0.40

### Mechanical Properties, Typical, All Weld Metal

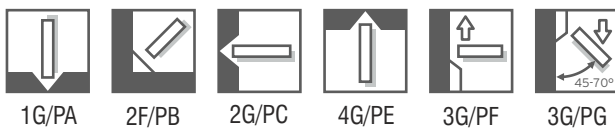
Yield Strength : 450 N/mm<sup>2</sup>  
 Tensile Strength : 540 N/mm<sup>2</sup>  
 Elongation (L=5d) : 25 %  
 Impact (ISO-V) : 60 J (0°C)

### Welding Parameters / Packing and Diameter Informations / Welding Positions

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

Diameter [ mm ]	Length [ mm ]	Current [ A ]	Electrode Weight [ g/100 pcs ]	Box Weight [ kg ] Quantity [ pcs/box ]	Export Box Box Weight [ kg ]
2.50	350	50 - 90	1860	1.8 / 100	5
3.25	350	80 - 130	2880	2.9 / 100	5
4.00	350	120 - 170 (*)	4500	4.5 / 100	5

(\*) It is recommended to work with 100-160 A when welding in vertical downwards position.



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### Applications and Materials to be Welded

Welding of boiler vessels, steel constructions, automotive bodies, steel plate works, ordinary ship's plates, some assembly processes, machinery fabrication and welds required in tubular structures are among its application areas.

	<u>DIN</u>	<u>EN</u>
<b>General Structural Steels</b>	St 33, St 35, 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
<b>Fine Grained Steels</b>	StE 255 - StE 420 WStE 255	S255N - S420N P255NH
<b>Pipe Materials</b>	StE 210-7 - StE 360-7 StE 290-7 TM - StE 360-7 TM X42, X46, X52 (API 5LX)	L210 - L360NB L290MB - L360MB -
<b>Boiler and Pressure Vessel Steels</b>	17 Mn 4, 19 Mn 6 H1, H11, H111	P295GH, P355GH P235GH, P265GH, P285NH
<b>Elevated Temperature Steels</b>	St 35-8, St 45-8	P235G1TH - P255G1TH
<b>Ship Plates</b>	A, B, D*	-
<b>Cast Steels</b>	GS-38, GS-45, GS-52	GE200, GE240, GE260

(\*) It is recommended to use a basic coated electrode in the root pass.