

LE R-143

CLASSIFICATION

AWS A5.1 E6013
EN ISO 2560-A E 42 0 RR12

GENERAL DESCRIPTION

LE 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.

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PE/4G



PF/3Gu

CURRENT TYPE

DC - ; AC min 50 V

APPROVALS

| ABS | BV | DNV | LRS | RINA | TL | CE | DB | TÜV |
|-----|----|-----|-----|------|----|----|----|-----|
| 2 | 2 | 2 | 2m | 2 | 2 | + | + | + |

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

| C | Mn | Si |
|------|------|------|
| 0.08 | 0.65 | 0.35 |

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

| | Condition | Yield strength (N/mm ²) | Tensile strength (N/mm ²) | Elongation (%) | Impact ISO-V(J) | |
|----------------|-----------|--|--|-------------------|-----------------|-------|
| | | | | | 0°C | -20°C |
| Typical values | AW | 480 | 550 | 25 | 60 | 40 |

PACKAGING AND AVAILABLE SIZES

| | Diameter (mm) | Length (mm) | Available Sizes | | | | | | |
|------------------|----------------------|-------------|-----------------|-----|-----|-----|-----|-----|-----|
| | | | 2.0 | 2.5 | 3.2 | 4.0 | 4.0 | 5.0 | 5.0 |
| | | | 300 | 350 | 350 | 350 | 450 | 350 | 450 |
| Carton + PE foil | Pieces / unit | | 195 | 100 | 100 | 100 | 100 | 65 | 65 |
| | Net weight/unit (kg) | | 2.1 | 2.1 | 3.2 | 4.8 | 6.7 | 4.9 | 6.4 |

Identification E6013 / LE R-143 Tip Color: none

All Information In this data sheet is accurate to the best of our knowledge at the time of printing

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EXAMPLES OF MATERIALS TO BE WELDED

LE 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 |