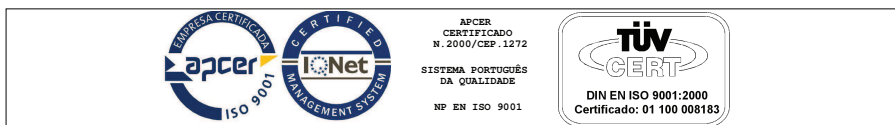


	TECHNICAL DESCRIPTION	FT-DT.32.05
	EUROTROD RN 15	PAGE 14/14

CERTIFIED COMPANY:



CLASSIFICATION:

AWS A5.1: E 6013
EN ISO 2560-A-E 38 Z RR 1 2

DESCRIPTION:

Medium coated rutile type electrode for universal application and non-alloyed structural steel, in special for thin plates. Automatic striking and restriking.

SUITABLE FOR:

St 33 to St 52.3	St 35.8 to 17 Mn 4	StE 255 to StE 355	GS-38 to GS-52
H I, H II, 17 Mn 4	StE 210.7 to StE 360.7	WStE 255 to WStE 355	
St 37.4 to St 52.4	StE 210.7 TM to StE 360.7 TM	A, B, D	

TYPICAL CHARACTERISTICS OF ALL-WELD METAL:

Chemical Analysis (%):

C	Si	Mn	P	S			
0,07	0,35	0,35	< 0,02	< 0,02			

Mechanical Properties:

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation 5d (%)		
>420	>470	>20		

PRODUCT INFORMATION:

WELDING PARAMETERS				PACKING DATA	
Diameter (mm)	Length (mm)	Recommended Current (A)	Current Type (Pole -)	Pieces /Packet (Un)	Weight /Packet (kg)
2,0	350	50 – 60	AC/DC	375	5,0
2,5	350	60 – 90	AC/DC	250	5,0
3,2	350	90 – 140	AC/DC	150	5,0
4,0	450	120 – 180	AC/DC	90	6,2
5,0	450	160 – 230	AC/DC	60	6,4

WELDING POSITIONS:

