Electro Portugal, Lda	TECHNICAL DESCRIPTION	FT-DT.30.08
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CERTIFIED COMPANY:

APCER CERTIFICADO N.2000/CEP.1272 SISTEMA PORTUGUES DA QUALIDADE NP EN ISO 9001

DIN EN ISO 9001:2000 Certificado: 01 100 008183

CLASSIFICATION:

AWS A5.1: E 6013
EN ISO 2560-A-E 42 A RC 1 1

DESCRIPTION:

Medium coated rutile-cellulose type electrode for universal application and non-alloyed structural steel. Good for all positional welding characteristics, including vertical-downward. Automatic striking and restriking.

SUITABLE FOR:

St 33 to St 52.3	St 35.8 to St 45.8	A, B	
H I – H II	StE 210.7 to StE 360.7	GS-38 to GS-52	
St 37.4 to St 52.4	StE 210.7 TM to StE 360.7 TM		

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 (%)	CHARPY V (J)	
			20°C	
>450	>500	>22	>47	

PRODUCT INFORMATION:

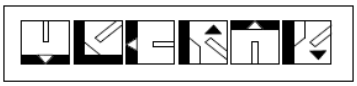
WELDING PARAMETERS				PACKING DATA	
Diameter (mm)	Length (mm)	Recommended Current (A)	Current Type (Pole -)	Pieces /Packet (Un)	Weight /Packet (kg)
2,0	350	50 – 70	AC/DC	420	5,1
2,5	350	60 – 90	AC/DC	280	5,3
3,2	350	90 – 140	AC/DC	180	5,2
3,2	450	90 – 140	AC/DC	180	6,7
4,0	350	120 – 180	AC/DC	100	4,6
4,0	450	120 – 180	AC/DC	115	6,8
5,0	450	160 – 230	AC/DC	65	6,1

APPROVALS:

- Lloyd's Register of Shipping: Cert. Nº LIS0900023
- G.L. (Germanischer Lloyd): Cert. Nº WF0860081HH
- DNV Cert. Nº W-21790

CE
1328
08
1328-CPD-0119
EN 13479 + ISO 2560 – A – E 42 A RC

WELDING POSITIONS:



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