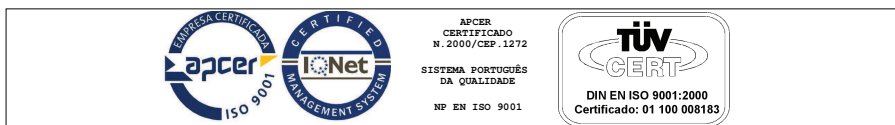


	<b>TECHNICAL DESCRIPTION</b>	FT-DT.31.05
	<b>EUROTROD RN 13</b>	PAGE 13/13

**CERTIFIED COMPANY:**



**CLASSIFICATION:**

**AWS A5.1: E 6013  
EN ISO 2560-A-E 42 Z RR 1 2**

**DESCRIPTION:**

Medium coated rutile type electrode for universal application and non-alloyed structural steel. Automatic striking and restriking.

**SUITABLE FOR:**

St 33 to St 52.3	St 35.8 to 17 Mn 4	StE 255 to StE 355	
H I, H II, 17 Mn 4	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	0,40	0,45	< 0,02	< 0,02			

**Mechanical Properties:**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	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	450	5,4
2,5	350	60 - 90	AC/DC	300	5,6
3,2	350	90 - 140	AC/DC	180	5,4
4,0	350	120 - 180	AC/DC	115	5,5
5,0	450	160 - 230	AC/DC	70	6,8

**WELDING POSITIONS:**

