

## RUTILE ELECTRODES - STEEL

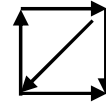
### Rutile Steel electrodes, general use:

- For metal carpentry
- Steel frame
- Sheet metal
- Maintenance



### PROPERTIES

- Easy initiation (first and following).
- Good welding in any positions.
- Flat to slightly curved cords and easy cleaning



### NORMALISATION

EN 499	AWS A 5.1	DIN 1913
E 42 0 RC11	E 6013	E 43 21 RC11

### TYPE OF CURRENT

- AC : Initiation as of 40V
- DC : Polarity (-) to the electrode

Ø mm		A
1,6	1,5	40
2,0	1,5 ▶ 3	55
2,5	2,5 ▶ 6	80
3,2	5 ▶ 8	115
4,0	8 ▶ +	150-160

### MECHANICAL CHARACTERISTICS and CHEMICAL COMPOSITION

#### MECHANICAL CHARACTERISTICS Norm AFNOR NF EN 1597.1

<b>Re</b>	440 MPa
<b>Rm</b>	540 MPa
<b>A 5 d</b>	24%
<b>KV 0°C</b>	50 j

#### CHEMICAL COMPOSITION Norm EN ISO 6847

<b>C</b>	0,06 %
<b>Mn</b>	0,50%
<b>Si</b>	0,40%
<b>S</b>	0,025%
<b>P</b>	0,025%

### PRINCIPAL STEEL TYPES

AFNOR : A 33 – A 34 – E 24 – E 28 – E 30 – A 37 CP – A 42 CP  
 DIN : ST 33.1 – ST 37.3 – ST 44 (2.3) H I – H II