

RUTWELD R3

Electrodes MMA [SMAW]

Construction, unalloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 2560-A : E 38 0 R 11 DIN 1913 : E 43 22 R3 AWS A-5.1 : E 6013	UDT	Agriculture Light construction and hobby

- Universal rutile electrode, for general use.
- Very friendly for the welder, does not require high welding skills and experience, provides great comfort of work.
- It does not require professional equipment for welding - small AC machines (230V and 380V) and DC +/- inverters can be used. The devices can even be connected to long or aluminum power cables.
- Easy to operate and control of the arc, great control of the weld pool, high flexibility of the arc, does not stick when approaching the welded element.
- Guaranteed 100% primary and secondary ignition in any position.
- Very good beads appearance.
- Possibility of welding in all positions.

Recommendations:

- Do not exceed the range of proper currents - welding with too high current causes an increase in the number of spatters, the formation of undercuts and insufficient coverage of the weld with slag.
- Do not overdry - excessive drying prior to use causes a decrease in penetration depth and overheating of the electrode.

Application

Steel constructions: trusses, portal frames, tubular frames. Sheet metal constructions and container sheathing, storage tanks, hoppers, silos. Connection of pipes for the transmission of various media in the field. Light steel frames - grills, furniture, gates, decorations. Welding of agricultural equipment. General workshop welding and maintenance. Welding all types of mild (low carbon) steel.


Base material

	EN
Unalloyed steels:	S/P235, S/P275

Typical chemical composition %

C	Si	Mn
0,08	0,35	0,60

Typical mechanical properties

Yield strength Re [N/mm2]	>380
Tensile strength Rm [N/mm2]	470-600
Elongation A5 [%]	>20
Impact energy Kv [J]	>47J (0°C) /
Coating type	rutile
Welding current	 U₀ < 50V



Welding parameters and packing

Ø	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]	Pcs/1 kg
2,5	350 /	50-85	4,5	13,5	53
3,2	350 /	85-130	4,5	13,5	32
4,0	350 /	130-180	4,5	13,5	20

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