

RUTWELD ARMCO

Electrodes MMA [SMAW]

Construction, unalloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 2560-A : E 38 AAR 12 DIN 1913 : E 43 11 RR 8 AWS A-5.1 : E 6013		Hardfacing and repairing Metallurgy (Steelworks)

- Thick coated rutile electrode.
- The weld deposit ensures high resistance to cracks caused by the action of molten zinc.
- Can be used for both alternating and direct current.
- Recommended AC welding with low line energy and low interpass temperature.

Application

For use in the manufacture and repair of galvanizing baths made of Armco iron and low carbon steels

Base material

1.0340 - M2 (Armco iron)

Typical chemical composition %

C	Si	Mn
0,03	0,15	0,20

Typical mechanical properties

Yield strength Re [N/mm²]	>380
Tensile strength Rm [N/mm²]	>440
Elongation A5 [%]	>22
Impact energy Kv [J]	>47J (0°C) /
Coating type	rutile

Welding current



Welding positions



Redrying	100°C / 1h
-----------------	------------

Welding parameters and packing

Ø	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]
3,2	350 /	80-140	5,0	15,0
4,0	350 /	120-200	5,0	15,0
5,0	350 /	160-280	5,0	15,0

METALWELD-FIPROM POLSKA spółka z o.o.

ul. Mikołajczyka 57, 41-200 Sosnowiec

+48 (32) 297 75 50 - 51

+48 (32) 297 75 88
export@metalweld.pl