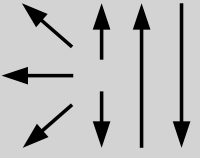


Classifications				
EN ISO 2560-A	EN ISO 2560-B	AWS A5.1	AWS A5.1M	
E 42 0 R 1 2	E 4312 A	E6012	E4312	
Characteristics and typical fields of application				
<p>Rutile covered electrode for general tank construction and structural engineering. Particularly suitable for welding sheets in all positions (2.0/2.5 mm \varnothing also in f-position). Soft arc; little spatter; excellent striking and restriking ability. Easy slag release. For use on small transformers (42 V, open circuit).</p>				
Base materials				
S235JRG2 - S355J2, weldable sheets				
Typical analysis of all-weld metal (wt.-%)				
	C	Si	Mn	
wt-%	0.08	0.35	0.50	
Mechanical properties of all-weld metal				
Heat-treatment	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A ($L_0=5d_0$)	Impact work ISO-V KV J
	MPa	MPa	%	+20 °C
aw	420	510	22	50
Operating data				
	Polarity:	\varnothing (mm)	L mm	Amps A
	DC (-) / AC	2.0	250	50 – 75
		2.5	350	65 – 100
		3.2	350	80 – 140
Approvals				
DB (10.132.10), CE				