

Classifications

EN ISO 2560-A:2006	: E 38 0 R 12	KS D 7004	: E4313
EN ISO 2560-B:2006	: E 43 12 A	JIS Z 3211	: E4312
AWS A5.1-04	: E6012		

Description

- Covering is high titania type for welding of shells of railway vehicles, cars and other steel structures and general light structural steels.
- Good weldability in vertical-down welding.
- Excellent X-ray quality and good bead appearance.
- Redry the electrode at 70-100°C for 30-60 minutes prior to use.

Welding positions**Typical chemical composition of all-weld metal (%)**

C	Si	Mn	P	S	Ni	Cr	Mo	V
0.07	0.39	0.52	0.020	0.011	0.02	0.03	0.01	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				RT	0°C	
AWS A5.1	min. 330	min. 430	min. 17			
EN ISO 2560-A	min. 380	470-600	min. 20		≥ 47	
Example	400	490	30	70	55	AW

* AW : As-Welded

Sizes available and recommended currents (AC or DC -)

Dia.	(mm)	2.6	3.2	4.0	5.0	6.0
Length	(mm)	350	350	400	400	450
Amp. (A)	F V · OH	50-95 40-95	80-120 70-110	130-170 100-140	180-230 120-160	240-300

Approvals

JIS, CE