



Classification:

EN 499: E 42 0 RR 12
 DIN 1913: E 51 22 RR 6
 AWS A-5.1: E 6013
 EN ISO 2560-A: E 42 0 RR 12
 EN ISO 2560-B: E 49 13 A

elektrode jesenice d.o.o.

RUTILEN 2000 S

Description and application:


Thick rutile coated electrode for welding low alloyed steels up to 510 N/mm². It has excellent welding characteristic.

Base materials:

Unalloyed steels:	DIN: St 33 to St 52.3	W.Nr.: 1.0035 to 1.0570
Boiler plates:	HI, HII, 17 Mn4	1.0345, 1.0425, 1.0481
Pipe steels:	St 35 to St 52.4	1.0308 to 1.0581
	StE 210.7 to StE 360.7	1.0307 to 1.0582
Shipbuilding plates:	A, B, D	1.0440, 1.0472, 1.0475
Steel castings:	GS-38 to GS-52	1.0416 to 1.0551
Thin sheets:	1623/1	

Coating type:
Rutile

Welding current:
AC
DC - / +

Welding positions:


Redrying temperature:
140°C / 1 h

Typical all weld metal properties:

Chemical composition, wt %:

C	Si	Mn
0.08	0.50	0.70

Mechanical properties:

Yield strength	R _{eL} / R _{p 0.2} :	> 420	MPa (N/mm ²)
Tensile strength	R _m :	510 – 610	MPa (N/mm ²)
Elongation	A ₅ :	> 22	%
Impact energy	KV:	> 47	J (0°C)

Welding and packing data:

Welding parameters			Packing		
φ mm	Length mm	Current A	Weight/ packet kg	Weight/ carton kg	Weight/ 1000 pcs kg *
2	300	50 – 70	4	20	
2.5	350	55 – 85	4	20	
3.25	350	90 – 135	4	20	
4	450	130 – 170	5.4	27	
5	450	175 – 220	5.4	27	

* approximate data

Approvals:

TÜV
DB