



Selectarc 40

*Rutile Electrode
For all positions*

Classification

AWS A5.1 : E6013

ISO 2560-A : E 42 0 RC 1 1

Description & Applications

Rutile cellulosic mild steel electrode to weld in all positions, including vertical down.

Main applications: Used for metal constructions, for piping systems, tanks, blacksmithing, craft works.

Base materials

Construction steels for general use, Tube steels, Ship steels:

EN- Designation	S185 – S355 P235 – P355	L210 – L360
Ship steels	Quality A and B	
ASTM	A285 grade C A442 grade 55, 60	A414 grade C, D, E, F A515 grade 55, 60, 65

Typical Weld Metal Composition (%)

C	Si	Mn	P	S	Fe
<0.10	0.3	0.5	<0.025	<0.025	Rem.

All Weld Metal Mechanical Properties

R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
>420	>510	>22	0°C >47

Welding Current & Instructions

Electrode	ØxL (mm)	2,0x300	2,5x350	3,2x350	4,0x350
Current	(A)	40-60	55-85	90-140	130-180

ind.12



= - ~ 45V

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