



# Selectarc 48SP

*Rutile Electrode  
For all positions*

## Classification

AWS A5.1 : E6013

ISO 2560-A : E 42 0 RC 1 1

## Description & Applications

Special rutile cellulosic mild steel electrode to weld in all positions, including vertical down. Good operability, easy striking, strong arc with low spatters, good penetration and easy slag removal- suitable for current supplies with low open arc voltage. Less sensitive when used on poor prepared pieces (oil, grease, oxides).

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

## Base materials

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

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

## Typical Weld Metal Composition ( % )

	C	Si	Mn	Cr	Ni	Mo	Cu	Nb	V	P	S	Fe
Min												
Max	0.20	1.00	1.20	0.20	0.30	0.2	0.3	0.05	0.05			Rem.
Type	<0.10	0.40	0.60	0.03	0.02	0.01	0.02	0.005	0.01	<0.025	<0.025	Rem.

## All Weld Metal Mechanical Properties

	R <sub>e</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
Min	420	500	22	0°C >47
Max		640		
Type	450	520	26	+20°C 90 0°C 80 -10°C 50

## Welding Current & Instructions

Electrode	ØxL ( mm )	2,0x300	2,5x350	3,2x350	3,2x450	4,0x350	4,0x450
Current	( A )	50	70	110	110	140	140



= - ~ 40V

FT En-526-180703

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