



# Selectarc 54

*Rutile Electrode  
Nice appearance*

## Classification

AWS A5.1 : E6013

EN 499 : E 42 0 RR 1 2

ISO 2560-A : E 42 0 RR 1 2

## Description & Applications

Heavy coated rutile electrode for general use. Especially recommended for downhand welding, for fillet welds and vertical up position. Soft arc, few spatters, self lifting slag, excellent bead appearance.

**Main applications:** Currently used for welding mechanical constructions, shipbuilding, blacksmithing, boiler making...

## 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	0.4	0.6	<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 )	
>400	510-580	>22	+20°C	>64
			0°C	>47
			-20°C	>28

## Welding Current & Instructions

Electrode	ØxL ( mm )	2,0x300	2,5x350	3,2x350	3,2x450	4,0x350	4,0x450	5,0x450
Current	( A )	55	70	115	115	150	150	180



= - ~ 45V

Ind.12



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