



Selectarc Galva 46

*Rutile Electrode
To be galvanised*

Classification

AWS A5.1 : E6013

EN 499 : E 35 0 RR 3 1

ISO 2560-A : E 35 0 RR 3 1

Description & Applications

Heavy coated Rutile electrode to weld steel constructions which will be galvanised after welding. Easy to use in all positions, also possible to weld short beads in vertical down position. Easy slag removal, regular rippled weld beads.

Main applications: Used in metal constructions, locksmithing ...

Base materials

EN- Designation	S235JR , S235JO , S235J2
ASTM	A283 grade B , C , D
	A570 grade 30 , 33 , 40

Typical Weld Metal Composition (%)

C	Si	Mn	P	S	Fe
0.06	0.3	0.2	<0.025	<0.025	Rem.

All Weld Metal Mechanical Properties

R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
400	460	25	+20°C 100 0°C >47

Welding Current & Instructions

Electrode	ØxL (mm)	2,0x300	2,5x350	3,2x350	4,0x450
Current	(A)	70	90	130	180



= - ~ 40V

ind.12



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