



# Selectarc RR B7

*Rutile-Basic Electrode*

*For root passes*

## Classification

AWS A5.1 : E6013

EN 499 : E 38 2 RB 1 2

ISO 2560-A : E 38 2 RB 1 2

## Description & Applications

Special rutile-basic coated electrode to weld in all positions. Especially designed for welding root passes. Good operability, easy striking, strong arc with low spatters, good penetration and easy slag removal. Supports high current.

**Main applications:** Used in metal constructions, for piping systems, tanks, locksmithing, 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	P	S	Fe
<0.10	0.3	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 )
>430	470-600	>20	+20°C 95 -20°C 60

## Welding Current & Instructions

Electrode	ØxL ( mm )	2,5x350	3,2x350	4,0x350	5,0x450
Current	( A )	70-90	100-140	140-180	200-260



= - ~ 40V

ind.12



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