

# RUTWELD 12

Electrodes MMA [SMAW]

Construction, unalloyed steels

<b>CLASSIFICATION:</b>  EN ISO 2560-A : E 38 0 RC 11 DIN 1913 : E 43 22 R(C)3 AWS A-5.1 : E 6012/E 6013	<b>APPROVALS:</b>  UDT TDT: E 38 0 RC 21	<b>APPLICATION:</b>  Constructions & Engineering Metallurgy (Steelworks) Mining Agriculture Light construction and hobby
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- A medium coated rutile-cellulose electrode recommended for welding in all positions, for assembly and workshop use, for universal usage.
- Excellent primary and secondary ignition.
- Flexible, stable electric arc, easy to operate in hard-to-weld positions, easy slag removal, does no need to require high welding experience.
- It can be welded with small 230 V hobby welding machines.
- An electrode for everyday use, for simple constructions, also for unexperienced welders.

### Application

Metal containers and tanks, light constructions, small machines and devices as well as steel tools.

### Base material

	EN
Construction steels:	S235-S275
Boiler plates:	P235GH-P275GH
Pipe steels:	L235-L295
Shipbuilding plates:	A, B, D

### Typical chemical composition %

C	Si	Mn
0,08	0,30	0,50

### Typical mechanical properties

<b>Yield strength Re [N/mm2]</b>	>380
<b>Tensile strength Rm [N/mm2]</b>	470-600
<b>Elongation A5 [%]</b>	>20
<b>Impact energy Kv [J]</b>	>47] (0°C) /
<b>Coating type</b>	rutile-cellulosic
<b>Welding current</b>	U <sub>0</sub> < 50V
<b>Welding positions</b>	
<b>Redrying</b>	110°C / 1h

### Welding parameters and packing

∅	Length [mm]	Welding	Weight of	Weight of	Pcs/1 kg
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		<b>current [A]</b>	<b>packet [kg]</b>	<b>carton [kg]</b>	
1,6	250 /	30-50	2,0	12,0	192-196
2,0	300 /	50-70	2,5	15,0	105-106
2,5	350 /	55-85	5,0	15,0	55-56
3,2	350 /	90-140	5,0	15,0	34
4,0	350 / 450 /	130-180	5,0/6,0	15,0/18,0	22/17
5,0	450 /	180-230	6,0	18,0	10

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