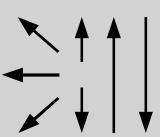


Classifications						
EN ISO 2560-A	EN ISO 2560-B	AWS A5.1	AWS A5.1M			
E 42 0 RC 1 1	E4312 A	E6013	E4313			
Characteristics and typical fields of application						
Rutile-cellulosic electrode with good weld ability in all positions including vertical down. Excellent gap-bridging and arc-striking ability. For tack welding and load fit ups. General purpose for industry and trade, assembly and shop welding						
Base materials						
Steels up to a yield strength of 380 MPa (52 ksi) S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, shipbuilding steels: A, B, D ASTM A 106 Gr. A, B; A 283 Gr. A, C; A 285 Gr. A, B, C; A 501 Gr. B; A 573 Gr. 58, 65; A 633 Gr. A, C; A 711 Gr. 1013 API 5 L Gr. B, X42, X52						
Typical analysis of all-weld metal						
	C	Si	Mn			
wt.-%	0.08	0.4	0.5			
Mechanical properties of all-weld metal – typical values (min. values)						
Condition	Yield strength R <sub>e0,2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J		
	MPa	MPa	%	+20°C	±0°C	
u	<b>440</b> (≥ 420)	<b>540</b> (500 – 640)	<b>22</b> (≥ 20)	<b>80</b>	<b>55</b> (≥ 47)	
u untreated, as welded						
Operating data						
	Polarity DC (-) / AC	Redrying: not necessary	Electrode identification: BÖHLER AWS E6013 E 42 0 RC 1 1	ø mm	L mm	Amps A
				2.0	300	40 – 60
				2.5	350	60 – 100
				3.2	350	90 – 140
				4.0	350	150 – 190
			5.0	450	190 – 240	
Approvals						
TÜV (12680.), ABS, DNV GL, CE						