

Rutile Coated Electrode for Mild Steels

Classification

EN ISO 2560-A : E 42 0 RC 11
 AWS A5.1 : E6013

General Description

AS R-144 is a rutile-cellulosic coated electrode. It can be used in all positions including vertical-downwards travel. As it is an easy to bend electrode, it brings great convenience to reach in difficult-to-reach areas. It has a good penetration respectively. The slag is easy to remove and it is very easy to strike and re-strike.

Chemical Composition (w%), Typical, All Weld Metal

C	Si	Mn
0.08	0.45	0.55

Mechanical Properties, Typical, All Weld Metal

Yield Strength	: 440 N/mm ²
Tensile Strength	: 550 N/mm ²
Elongation (L=5d)	: 25 %
Impact (ISO-V)	: 50 J (0°C)

Approvals

GOST, SEPRO, TSE

Welding Parameters / Packing and Diameter Informations / Welding Positions

Current Type and Polarity : AC min 50 V ; DC (-)

Diameter [mm]	Length [mm]	Current [A]	Electrode Weight [g/100 pcs]	Box Weight [kg] Quantity [pcs/box]	Export Box Box Weight [kg]
2.50	350	70 - 100	1830	1.8 / 100	5
3.25	350	90 - 150	3040	3.0 / 100	5
4.00	350	140 - 200	4320	5.6 / 130	5
5.00	350	160 - 230	6700	5.4 / 80	5



1G/PA



2F/PB



2G/PC



4G/PE



3G/PF



3G/PG

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Applications and Materials to be Welded

Welding of boiler vessels, steel constructions, automotive bodies, steel plate works, ordinary ship's plates, some assembly processes, machinery fabrication and welds required in tubular structures are among its application areas.

	<u>DIN</u>	<u>EN</u>
General Structural Steels	St 33, St 35, St 37, St 44, St 44-2, St 44-3, St 52, St 52-3 St 37-4, St 44-4, St 52-4	S185, S235, S275, S355 P235TR2 - P355T2
Fine Grained Steels	StE 255 - StE 420 WStE 255	S255N - S420N P255NH
Pipe Materials	StE 210-7 - StE 360-7 StE 290-7 TM - StE 360-7 TM X42, X46, X52 (API 5LX)	L210 - L360NB L290MB - L360MB -
Boiler and Pressure Vessel Steels	17 Mn 4, 19 Mn 6 H1, H11, H111	P295GH, P355GH P235GH, P265GH, P285NH
Elevated Temperature Steels	St 35-8, St 45-8	P235G1TH - P255G1TH
Ship Plates	A, B, D*	-
Cast Steels	GS-38, GS-45, GS-52	GE200, GE240, GE260

(*) It is recommended to use a basic coated electrode in the root pass.