

Rutile Coated Electrode for Mild Steels

Classification

EN ISO 2560-A : E 38 0 R 12
 AWS A5.1 : E6013

General Description

AS R-146 is a medium coated general purpose rutile electrode. It is a very easy to use electrode. The slag is easy to remove and it gives high quality, smooth weld beads. It is easy to strike and re-strike and thus it is an ideal electrode for tacking .

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

C	Si	Mn
0.07	0.20	0.40

Mechanical Properties, Typical, All Weld Metal

Yield Strength	: 400 N/mm ²
Tensile Strength	: 480 N/mm ²
Elongation (L=5d)	: 25 %
Impact (ISO-V)	: 60 J (0°C)

Approvals

CE, GOST, SEPRO, TSE

TL

2

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	60 - 100	1990	2.0 / 100	5
3.25	350	110 - 140	3190	3.2 / 100	5
4.00	350	140 - 200	4790	4.8 / 100	5



1G/PA



2F/PB



2G/PC



4G/PE



3G/PF

Rutile Coated Electrode for Mild Steels

Applications and Materials to be Welded

Welding of structures in thin and medium thick plates in all positions, bridging over the large gaps in steel constructions, welding of galvanized plates are among its application areas. AS R-146 is relatively insensitive to rust and other surface impurities and recommended especially for welding ordinary ship steels and for structural steels having similar mechanical strength and quality.

	<u>DIN</u>	<u>EN</u>
General Structural Steels	St 33, St 34, St 37, St 44, St 44-2, St 44-3 St 37-4, St 44-4	S185, S235, S275 P235TR2 - P275T2
Fine Grained Steels	StE 255 - StE 285 WStE 255	S255N - S275N P255NH
Pipe Materials	StE 210-7 - StE 290-7 X42, X46 (API 5LX)	L210 - L290NB -
Boiler and Pressure Vessel Steels	17 Mn 4, 19 Mn 6 HI, HII, HIII*	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.