EN 499:1994: E 42 0 RR 1 2
AWS A5.1-04: E6013
AWS A5.1M-04: E4313

BÖHLER FOX ETI

SMAW stick electrode, mild steel, rutile-coated

Description

Rutile coated electrode offering top weldability in all positions except vertical-down. Extremely smooth beads, self-detaching slag, minimum spattering and excellent welding properties on A.C. Excellent restriking characteristics and easy handling. Good deposition lengths attainable. Versatile applications in trade and industry.

Typical Composition of All-weld Metals

	C	Si	Mn
wt-%	**0.07**	**0.4**	**0.5**

Mechanical Properties of All-weld Metal

(*)		u	
Yield strength R_e N/mm²:		**460**	(≥ 420)
Tensile strenght R_m N/mm²:		**520**	(500 - 640)
Elongation A ($L_o = 5d_o$) %:		**26**	(≥ 20)
Impact work ISO-V KV J	+ 20 °C:	**65**	(≥ 50)
	± 0 °C:	**50**	(≥ 47)

(*) *u untreated, as-welded*

Operating Data

re-drying: not necessary

Electrode identification:
FOX ETI 6013 E 42 0 RR

ø mm	L mm	amps A
1.5	250	40 - 60
2.0	250	45 - 80
2.5	250/350	60 - 110
3.2	350/450	90 - 140
4.0	450	110 - 190
5.0	450	170 - 240

Base Materials

steels up to a yield strength of 420 N/mm² (60 ksi)

S275JR, S235J0G3 - S355J0G3, P235GH, P265GH, P255NH, P295GH, P235T1, P355T1, P235T2-P355T2, P235G1TH, P255G1TH, L210 - L360NB, L290MB, S235JRS1 - S235J0S1, S235JRS2 - S235J0S2

ASTM A36 a. A53 Gr. all; A106 Gr. A, B, C; A 135 Gr. A, B; A283 Gr. A, B, C, D; A366; A285 Gr. A, B, C; A500 Gr. A, B, C; A570 Gr. 30, 33, 36, 40, 45; A607 Gr. 45; A668 Gr. A, B; A907 Gr. 30, 33, 36, 40; A935 Gr. 45; A936 Gr. 50; API 5 L Gr. B, X42 - X56

Approvals and Certificates

TÜV-D (1097.), TÜV-A (450), ABS (2), BV (2), DNV (2), FI (E 42 0 RR 12), GL (2), LR (2m), UDT, LTSS, SEPROZ

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