BOHLER FOX S ETI

Unalloyed Rutile

Classifications

EN ISO 2560-A	AWS A5.1		
E 42 0 RR 12	E6013		

Characteristics and typical fields of application

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

Base materials

Steels up to a yield strength of 420 MPa (60ksi)

S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, L415NB, L415MB,

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, 70; A 633, Gr. A, C; A 711 Gr. 1013; API 5 L Gr. B, X42, X52, X60

Typical analysis of all-weld metal (wt.-%)

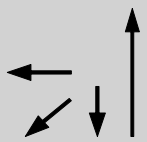
	C	Si	Mn
wt.-%	0.07	0.4	0.5

Mechanical properties of all-weld metal

Heat-treatment	Yield strength R_e	Tensile strength R_m	Elongation A (L_0=5d_0)	Impact work ISO-V KV J	
	MPa	MPa	%	+20 °C	±0 °C
u	430	520	26	65	50

u untreated, as welded

Operating data



Polarity

DC – and AC

Electrode Identification : **Fox S ETI /6013**

Preheated and interpass temperature as required by the base material.

Approvals

ABS (2)

Size, Packaging and Electrical Operating Data

Size (mm)		Carton Pack		Amperage (A)
Ø	Length	Kg / Pack	Kg / Box	
2.50	350	5.0	20.0	60 – 90
3.25	350 / 450	5.0	20.0	90 – 130
4.00	350 / 450	5.0	20.0	110 – 180
5.00	450	5.0	20.0	170 - 220