

EZ - 11 F

CLASSIFICATION

EN ISO 2560-A	AWS / ASME SFA-5.1
E 42 0 RR 12	E6013

DESCRIPTION AND APPLICATION

A heavily coated rutile electrode for welding of steels with tensile strength up to 510 N/mm². Distinguished by consistent welding arc, excellent slag detachment and fine smooth welds.

Steel grade	HRN	DIN (W. Nr.)		EN / ISO
Constructional steels	Č 0261 to Č 0563	St 33 (1.0035) to St 52-3N (1.0570)		S 185 to S 355J2G3 Fe 310-0 to Fe 510 D1
Boiler steels	Č 1202 Č 1204 Č 3133	HI (1.0345) 17Mn4 (1.0481)	HI1 (1.0425)	P235GH P265GH P295GH
Tube and pipe steels	Č 1212 to Č 3100	St 35.4 (1.0309) to St 52.4 (1.0581) StE 210.7 (1.0307) to StE 360.7 (1.0582)		DX55D to P355T2 L210 to L360NB
Shipbuilding steels	A, B, D	A, B, D		
Cold-reduced steel sheet	Č 0146 to Č 0148	St 12 (1.0330) to St 14 (1.0338)		Fe P01 to Fe P04

MECHANICAL PROPERTIES OF THE ALL-WELD METAL

R _{eL} N/mm ²	R _m N/mm ²	A ₅ %	KV (0°C) J
> 420	500 - 640	> 20	≥ 60

APPROXIMATE CHEMICAL COMPOSITION OF THE ALL-WELD METAL

	C	Mn	Si
%	0,08	0,6	0,35

RECOMMENDED WELDING CURRENT

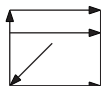
Ø mm	2,0	2,5	3,2	4,0	5,0	6,0
A	50 - 70	60 - 95	110 - 150	140 - 200	200 - 270	230 - 300

PACKAGING

Electrode dimensions mm	Quantity per ton approx. pieces	Weight of packaging kg
Ø 2,0 x 300	89 200	0,8; 3,7
Ø 2,5 x 300	54 300	0,8; 3,5
Ø 3,2 x 350	27 900	0,8; 4,3
Ø 4,0 x 450	14 700	5,3
Ø 5,0 x 450	10 000	5,4
Ø 6,0 x 450	6 700	5,2

APPROVALS

ABS (2); BV (2); CRS (2); DB; DNV (2); GL (2); LR (2); TÜV



Marking: **EZ - 11 F**