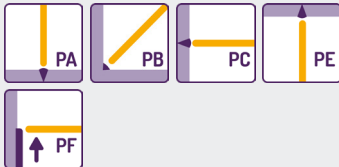


Processing information

Welding positions:



Polarity:



Application

With a molybdenum content of 0.4 % this electrode is especially suitable for steel 16Mo3 in boiler, container and pipeline construction. It provides a smooth, finely rippled and notch-free seam surface. This rod electrode is very well suited for root welding.

Field



**Characteristic
rutile-coated**

Standards

**ISO 3580-A
E Mo R 12**

**AWS A 5.5
E 7013-G**

Approvals



Materials

Construction steels	S235 bis S355
Fine-Grained steels	S275 bis S355
Ship steels	A32/36, D32/36, A40, D40
Boiler steels	P195 bis P355, 16Mo3
Pipe steels	L210 bis L360
Cast steels	GP 240, G20Mo5

All Weld Metal Mechanical Properties

Heat Treatment	SR		
Weld Metal Composition [%]			
C	Si	Mn	Mo
0,1	0,2	0,5	0,4
Yield Strength Re [MPa]	> 460		
Tensile Strength Rm [MPa]	560-600		
Elongation A5 [%]	> 25		
Charpy Impact Value ISO-V [J/+20 °C]	> 55		

Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.550.253	2,50/350	90 - 110	4,8	240	20,0
00.550.323	3,25/350	110 - 150	5,0	152	32,9
00.550.404	4,00/450	160 - 190	6,0	96	62,5



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