BÖHLER FOX KE

Stick electrode, unalloyed, rutile coated

Classifications

EN ISO 2560-A	AWS A5.1 / SFA-5.1
E 38 0 RC 1 1	E6013

Characteristics and typical fields of application

Rutile-cellulosic coated electrode engineered for easy operating in all positions including vertical-down. Excellent welding properties on A.C., good striking and restriking characteristics, sound penetration, flat beads; popular for general steel construction.

Base materials

Steels up to a yield strength of 380 MPa (52 Ksi) S235JR-S355JR, S235J0-S355J0, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB. Ship building steels: A, B, D 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; A 633, Gr. A, C; A 711 Gr. 1013; API 5 L Gr. B, X42, X52

Typical analysis

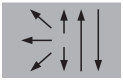
	C	Si	Mn
wt.-%	0.06	0.3	0.5

Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength R_e	Tensile strength R_m	Elongation A (L_o=5d_o)	Impact energy ISO-V KV J		
	MPa	MPa	%		0°C	-10°C
u	430 (≥380)	490 (470 – 600)	26 (≥20)	75	65 (≥47)	50

u untreated, as welded

Operating data



Polarity	DC- / AC
Electrode identification	FOX KE 6013 E 38 0 RC

Dimension mm	Current A
2.0 × 250	45 - 80
2.5 × 250	60 - 100
2.5 × 350	60 - 100
3.2 × 350	90 - 130
4.0 × 350	110 - 170
4.0 × 450	110 - 170
5.0 × 450	170 - 240

Approvals

LR (2m)