

EN 499: E 38 2 RB 1 2
 AWS A5.1-91: E 6013 (mod.)
¹⁾ DIN 1913: E 43 43 RR (B) 7
¹⁾ BS 639: E 43 43 RR 22
¹⁾ NFA 81-309: E 43 4/3 RR 22

BÖHLER FOX SPE

**SMAW stick electrode
 mild steel, rutile-basic-coated**

¹⁾ replaced by EN 499

Description

Thick coated rutile-basic electrode especially recommended for out-of-position work except vertical-down. Excellently suited for welding root passes. Produces first class X-ray quality welds.

Preferably used in structural and tank welding as well as in tube&pipe construction.

Typical Composition of All-weld Metal

	C	Si	Mn
wt-%	0.08	0.2	0.5

Mechanical Properties of All-weld Metal

	u	
yield strength R_e N/mm ² :	420	(≥380)
tensile strength R_m N/mm ² :	500	(470-600)
elongation A ($L_0=5d_0$) %:	28	(≥20)
impact work ISO-V KV J	+20°C:	90 (≥70)
	±0°C:	75 (≥60)
	-10°C:	70 (≥50)
	-20°C:	60 (≥47)

u untreated, as-welded

Operating Data



re-drying: **not necessary**
 electrode identification:
FOX SPE E 38 2 RB

ø mm	L mm	amps A
2.0	250	45-75
2.5	250/350	60-100
3.2	350	90-140
4.0	450	110-190
5.0	450	170-250



Base Materials

steels up to a yield strength of 380 N/mm²

S275JR, S235J2G3 - S355J2G3, P235GH, P265GH, P255NH, P355T1, P235T2-P355T2, P235G1TH, P255G1TH, L210 - L360NB, L290MB - L360MB, S235JRS1 - S235J4S

ASTM A36 u 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, X52

Approvals and Certificates

TÜV-D, TÜV-Ö, DB (10.014.03), ABS, BV, CL, DNV, GL, LR, RMR, ÖBB (10.01.004), UDT, LTSS, Ü, SEPROS