



elektrode jesenice d.o.o.

# EMONA

## Classification:

GOST 9467-60:	E 46-T
EN 499:	E 35 2 RB 12
DIN 1913:	E 43 43 RR(B)7
AWS A-5.1:	E 6013
EN ISO 2560-A:	E 35 2 RB 12
EN ISO 2560-B:	E 43 03 A

## Description and application:

Thick basic-rutile coated electrode for welding low alloyed steels with tensile strength up to 510 N/mm<sup>2</sup>. The weld metal deposit has high mechanical properties and can be used for a wide range of materials.

## Base materials:

Unalloyed steels:	DIN: St 33 to St 52.3	W.Nr.: 1.0035 to 1.0570
Boiler plates:	HI, HIII, 17Mn4	1.0345, 1.0435, 1.0481
Pipe steels:	St 35 to St 52.4	1.0308 to 1.0581
	StE 210.7 to StE 360.7	1.0307 to 1.0582
Shipbuilding plates:	A, B, D, E	1.0440 to 1.0476
Steel castings:	GS-38 to GS-52	1.0416 to 1.0551
Finegrained steels:	StE 255 to StE 355	1.0461 to 1.0562

## Coating type:

Basic-rutile

## Welding current:

AC  
DC -

## Welding positions:



## Redrying temperature:

140°C / 1 h

## Typical all weld metal properties:

### Chemical composition, wt %:

C	Si	Mn
0.10	0.20	0.55

### Mechanical properties:

Yield strength	R <sub>eL</sub> / R <sub>p 0.2</sub> :	> 360	MPa (N/mm <sup>2</sup> )
Tensile strength	R <sub>m</sub> :	450 - 540	MPa (N/mm <sup>2</sup> )
Elongation	A <sub>5</sub> :	> 24	%
Impact energy	KV:	> 47	J (-20°C)

## Welding and packing data:

Approvals:	
CR:	3
ABS:	3
BV:	3
GL:	3
LR:	3
DNV:	3
RS:	3
TÜV	
SŽ	
PRS:	3
SZU	

Welding parameters			Packing		
φ mm	Length mm	Current A	Weight/ packet kg	Weight/ carton kg	Weight/ 1000 pcs kg *
2	300	55 - 70	4	20	11
2.5	300	70 - 90	4	20	17.1
3.25	350	115 - 145	4.4	22	32.8
4	450	145 - 190	6	30	62.5
5	450	200 - 250	6	30	98.4
6	450	250 - 290	6	30	142.9

\* approximate data