BÖHLER FOX KE

Rutile-cellulosic stick electrode, unalloyed

Classification

EN ISO 2560-A	EN ISO 2560-B	AWS A5.1	AWS A5.1M
E 38 0 RC 1 1	E4313 A	E6013	E4313

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, S235JO-S355JO, 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 of all-weld metal (wt.-%)

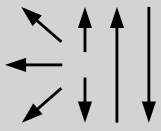
	C	Si	Mn
wt.-%	0.06	0.3	0.5

Mechanical properties of all-weld metal

Condition	Yield strength R_e	Tensile strength R_m	Elongation A (L_0=5d_0)	Impact work ISO-V KV J		
	MPa	MPa	%	+20 °C	±0 °C	–10 °C
u	**430** (≥ 380)	**490** (470 – 600)	**26** (≥ 20)	**75**	**65** (≥ 47)	**50**

u untreated, as welded

Operating data



Polarity:	Electrode identification:	ø (mm)	L mm	Amps A
DC (–)	FOX KE 6013 E 38 0 RC	2.0	250	45 – 80
AC		2.5	250/350	60 – 100
		3.2	350	90 – 130
		4.0	350/450	110 – 170

Approvals

LR (2m), SEPROZ