



Selectarc 48SP

*Rutile Electrode
For all positions*

Classification

AWS A5.1 : E6013 EN 499 : E 42 0 RC 1 1
ISO 2560-A : E 42 0 RC 1 1

Description & Applications

Special rutile cellulosic mild steel electrode to weld in all positions, including vertical down. Good operability, easy striking, strong arc with low spatters, good penetration and easy slag removal- suitable for current supplies with low open arc voltage. Less sensitive when used on poor prepared pieces (oil, grease, oxides).

Main applications: In metal constructions, for piping systems, tanks, blacksmithing, craft works.

Base materials

Construction steels for general use, Tube steels, Ship steels

EN- Designation	S185 – S355 P235 – P355	L210 – L360
Ship steels	Quality A and B	
ASTM	A285 grade C A442 grade 55, 60	A414 grade C, D, E, F A515 grade 55, 60, 65

Typical Weld Metal Composition (%)

C	Si	Mn	P	S	Fe
<0.10	0.4	0.6	<0.025	<0.025	Rem.

All Weld Metal Mechanical Properties

R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)	
450	520	26	+20°C	90
			0°C	80
			-10°C	50

Welding Current & Instructions

Electrode	ØxL (mm)	2,0x300	2,5x350	3,2x350	3,2x450	4,0x350	4,0x450
Current	(A)	50	70	110	110	140	140

Ind.12



= - ~ 40V



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