

***selectarc***

**R63**

**Rutile Electrode  
for low alloyed steels**

  
**FSH WELDING GROUP**  
INNOVATIVE WELDING CONSUMABLES  
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#### Classification

AWS A5.5 : E8013-G                      EN 1599 : E CrMo1 R 32  
ISO 3580-A : E CrMo1 R 32

#### Description & Applications

Rutile coated electrode alloyed with chrome and molybdenum for welding low alloyed steels, creep resistant steels ( 1%Cr and 0.5%Mo ) as well as heat-treatable steels and nitriding steels .  
Service temperature up to 550°C.

Very good welding characteristics, soft arc, easy slag removal, regular weld beads.

#### Base materials

Steels and pipes for boiler and pressure vessels:  
NF A 36-206 : 15D3 , 18MD4.05 , 15CD2.05 , 15CD4.05  
DIN 17155 : 13CrMo4 4 , 15CrMo3 , 13CrMoV4 2 ,  
DIN 1681 : A283grB. C, D. A570gr30, 33, 40.  
ASTM : A537 , A299 , A355 grade P11 and P12  
Heat treatable steels:  
NF A 35-551 : 18CD4 , 16CM5  
DIN : 25CrMo4 , 34CrMo4  
Material N° : 1.7218 , 1.7220

#### Typical Weld Metal Composition ( % )

C	Si	Mn	Cr	Mo	P	S
<0.10	0.4	0.6	1.1	0.5	<0.025	<0.025

#### All Weld Metal Mechanical Properties

Re ( MPa )	Rm ( MPa )	A5 ( % )	KV ( J )
>490	>590	>20	+20°C >50

#### Welding Current & Instructions

Electrode	ØxL ( mm )	2,5x350	3,2x350	4,0x350
Current	( A )	90	120	150

Redrying: 1h / 150°C . Preheating of the joints to weld: 200-250°C. Interpass temperature: 150-250°C.  
A post welding heat treatment is advised: 1-2h / 700°C.



1G/PA



2F/PB



2G/PC



3G/PF



4G/PE

= - ~ 60V

ind.05



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