

# Rod Electrodes



## Normal green

Rod electrode: E 42 0 RR12 EN ISO 2560-A  
 AWS: A 5.1: E 6013  
 Coating: rutil

dia. in mm	Length in mm	Amp. in A	Weight in kg	Art. No.	P. Qty.
2.0	300	40– 80	4.0	<b>0982 2</b>	360
2.5	350	50–110	4.7	<b>0982 25</b>	220
3.2	350	80–150	4.7	<b>0982 325</b>	130

### Properties:

- Good weldability in all positions, incl. in gently descending position (10–20°).
- Particularly suitable for galvanized steel on galvanized steel.
- Good re-ignition.
- Few splash losses.
- Easy slag removal.
- Clean weld texture.
- Maximum operating temperature 450°C.

**Welding positions:** 

### Welding instructions:

The electrode has to be welded with direct current -pole (+pole) and with alternating current.

### Applications:

Welded joints in steel construction, vehicle construction, mechanical engineering, container and boiler construction on unalloyed steels such as St. 33 – St. 52, boiler plate H I – H III, St. 35.8, St. 45.8, GS 38 – GS 52, also suitable for thin sheet welds.  
 Approvals, suitability tests: DB, TÜV.

## Universal blue

Rod electrode: E 38 0 RC 11 EN ISO 2560-A  
 AWS: A 5.1: E 6013  
 Coating: rutil cellulose

dia. in mm	Length in mm	Amp. in A	Weight in kg	Art. No.	P. Qty.
2.0	300	50– 70	4.6	<b>0982 21</b>	480
2.5	350	70–100	5.1	<b>0982 251</b>	300
3.2	350	90–150	5.4	<b>0982 325 1</b>	190
4.0	350	110–200	5.2	<b>0982 41</b>	120

### Properties:

- Good weldability in all positions, **especially** in a descending position.
- Good gap closure.
- Suitable for steel to galvanized steel / bright steel joints.
- Easy slag removal.
- Clean weld texture.
- Good re-ignition.
- Maximum operating temperature 350°C.

**Welding positions:** 

### Welding instructions:

The electrode has to be welded with direct current -pole (+pole) and with alternating current.

### Applications:

Welded joints in steel construction, vehicle construction, container and boiler construction and shipbuilding on unalloyed steels such as St. 33 – St. 52, boiler plate H I – H III, 17Mn4, GS 38 – GS 52.  
 Approvals, suitability tests: DB, TÜV.

## Special white

Rod electrode: E 38 2 B 32 H 10 EN ISO 2560-A  
 AWS: A 5.1: E 7016  
 Coating: basic

dia. in mm	Length in mm	Amp. in A	Weight in kg	Art. No.	P. Qty.
2.5	350	50– 90	4.2	<b>0982 252</b>	200
3.2	350	90–150	4.5	<b>0982 325 2</b>	130

### Properties:

- Thick-coated, chalk-based AC/DC special electrode, also suitable for welding on miniature welding transformers.
- In contrast to the welding properties of chalk-based electrodes that were previously claimed as characteristic, Special white flows very smoothly with only slight splash losses.
- Optimum weldability in awkward positions.
- Notch-free weld seam transitions on fillet welds.
- Even weld texture.
- Good slag coverage.
- Easy slag solubility.
- Maximum operating temperature 450°C.

**Welding positions:** 

### Welding instructions:

The electrode has to be welded with direct current +pole and alternating current.

### Applications:

Suitable for welded joints in steel construction, boiler construction, container construction, shipbuilding and mechanical engineering on unalloyed steels such as St. 33 – St. 50, St. 35.8, St. 45.8, GS 38 – GS 52, boiler plate H I – H III, 17Mn4, fine grained structural steels StE. 26 – StE. 36.  
 Can be used in industry and crafts for assembly, workshop and repair welds.  
 Approvals, suitability tests: DB, TÜV.