

# ESR 35

Rutile-Basic Electrode - Non Alloyed Steels

Standards	
AWS/ASME SFA - 5.1	E6013
EN ISO 2560 - A	E 38 2 RB 12
TS EN ISO 2560 - A	E 38 2 RB 12

Approvals & Certificates		
DB	CE	TUV

## Properties and Applications

Rutile-basic type coated electrode, particularly suitable for welding root passes and positional welding in fabrication of pipes, boilers and tanks. Also suitable for depositing backing-up beads in submerged arc welding. Owing to its low Si-content, weld metal is suited for subsequent galvanizing and enamelling.



## Typical Chemical Values of Weld Metal

Type of Analysis	C	Si	Mn
Weld Deposit	0.08	0.20	0,50

## Typical Mechanical Values of Weld Metal

Test Condition	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation A5 (%)	Charpy V-Notch Properties (J)		
As welded	480	530	23	20°C → 100	0°C → 60	-20°C → 50

## Application Information

### Welding Positions



### Polarity:



### Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
2.50x350	60-90
3.25x350	100-140
5.00x450	200-240
4.00x350	140-180

## Packaging Information

Product Code	Diameter X Length (mm)	Pieces per Box (-)	Weight Of The Box (kg)	Boxes Per Package	Weight Of The Package	Packaging Type
11106HREM2	2.50x350	246 pcs	5.0	3	15.4	Cardboard Box
11106NREM2	3.25x350	147 pcs	5.0	3	15.4	Cardboard Box
11106QREM2	4.00x350	100 pcs	5.0	3	15.4	Cardboard Box
11106VSEM2	5.00x450	64 pcs	6.5	3	19.9	Cardboard Box

#### Storage & Re-Drying Information

Generally not required. If required, redry for 1 hour at 110°C.