

ESR 11BLUE

Rutile-Cellulosic Coated Electrode - Non Alloyed Steels

Standards	
AWS/ASME SFA - 5.1	E6013
EN ISO 2560 - A	E 42 0 RC 11
TS EN ISO 2560 - A	E 42 0 RC 11
Properties and Applications	
Especially suitable for welding in sheets thinner than 5 mm, galvanized sheets and tubes, primer painted, painted and slightly rusty steels and in production of tanks and boilers, tube installations. Very easily operated in positional welding, including vertically-down. Good gap-bridging. Smooth arc, well suited for tack-welding due to its easy arc striking and re-striking properties. Possible to use equally well both with AC and DC. Welds are smooth, slightly concave and blending into base metal without undercutting. Slag is self-releasing.	

Materials	
EN	DIN
S185 - S355J0	St 33 - St 52-3
P235GH, P265GH	H I, H II
P295GH	17Mn4
P235TR2 - P355T2	St 37.4 - St 52.4
P235G1TH, P255G1TH	St 35.8, St 45.8
L210 - L360NB	StE 210.7 - StE 360.7
S255N - S355N	StE 255- StE 355
GE 200, GE 240	GS 38, GS 45
	AH 32, EH 36
	A, B, D

Typical Chemical Values of Weld Metal (%)

Type of Analysis	C	Si	Mn
Weld Deposit	0.06	0.40	0.40

Typical Mechanical Values of Weld Metal

Test Condition	Yield Strength (N/mm²)	Tensile Strength (N/mm²)	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	450	540	25	0°C → 55

Application Information

Welding Positions



Polarity:



Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
3.25x350	90-130
2.50x350	60-85
2.00x350	40 - 60
4.00x350	130-180

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
11108EQFM2	2.00x350	198	2.5	6	15.4	Cardboard Box
11108HQFM2	2.50x350	136	2.5	6	15.4	Cardboard Box
11108NQFM2	3.25x350	84	2.5	6	15.4	Cardboard Box
11108QQFM2	4.00x350	54	2.5	6	15.4	Cardboard Box

Storage & Re-Drying Information

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