

KRATOS M

Rutile ELECTRODE/ SMAW

Standards

EN/ISO-Standard - 2560-A
EN/ISO-Classification - E 38 0 R 12

AWS-Standard - A5.1
AWS-Classification - E6013

Features and Applications

- Rutile type medium coated electrode used on a wide variety of C-Mn and low-alloy applications.
- Excellent for pipe welding and construction works.
- Exceptional overall operability resulting in high quality weld deposits.
- Stable arc, low spatter, smooth weld bead appearance and self-releasing slag.
- Factory fresh vacuum-sealed aluminium packaging.
- Re-drying not generally required. If necessary 100-110 °C for 1 hour.
- **Test Certificates can be found online @wilkinsonstar247.com**



Typical Base Materials

S(P)235 to S(P)355; GP240; GP280*

* Illustrative, not exhaustive list

Welding Positions

EN ISO 6947 - PA, PB, PC, PF, PE, PF2

Polarity

AC; DC (+)(-)

Welding Parameters

| Ø mm | 2.00 | 2.50 | 3.20 | 4.00 | 5.00 |
|-------------|-------|-------|--------|---------|---------|
| Current (A) | 40-70 | 60-90 | 90-140 | 140-190 | 180-240 |

Mechanical Properties

| Tensile Strength (N/mm ²) | Yield Strength (N/mm ²) | Elongation (%) | Impact Strength (J) | Test Temperature |
|---------------------------------------|-------------------------------------|----------------|---------------------|------------------|
| 470-600 | ≥380 | ≥22 | ≥50 | 0°C |

Mechanical properties are approximate and may vary based on the heat, welding parameters and other factors.

Analysis of all-weld metal % (Typical)

| C % | Si % | Mn % | P % | S % |
|------|------|------|------|------|
| 0.08 | 0.30 | 0.50 | 0.03 | 0.03 |

Packaging Data

| Part No. | Diameter x Length Ø (mm) | Packet Weight (Kg) | Electrode Pieces Per/Packet | Carton Weight (Kg) |
|------------|--------------------------|--------------------|-----------------------------|--------------------|
| 8011100170 | 2.00 x 300 | 5 | ~470 | 15 |
| 8011100173 | 2.50 x 350 | 5 | ~259 | 15 |
| 8011100176 | 3.20 x 350 | 5 | ~161 | 15 |
| 8011100179 | 4.00 x 450 | 5 | ~84 | 15 |
| 8011100182 | 5.00 x 450 | 5 | ~55 | 15 |

Liability: Whilst all reasonable efforts have been made to ensure the accuracy of the information contained, this information is subject to change without notice and can be only considered as suitable for general guidance.

