

PHOENIX BLAU

Un-alloyed, rutile-cellulose coated stick electrode

Key feature

Stick electrode for general purpose, for un-alloyed steels up to a yield strength of 420 MPa





Product features	Product benefits	User benefits
» Rutile-cellulose coated	» General purpose for all welding positions	» Easy to use
» Designed for easy handling	» Tack welding in bad conditions » Good gap-bridging-ability	» Weld complex parts easily » More tolerant regarding gaps
» Intense arc	» Well suited to weld rusty or primed plates	» Less preparation and pre-weld-cleaning » Saves time and money » For high demanding industries



Typical applications

- » Steel constructions
- » Ship building
- » Fitter's shops

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Classifications		Operating data	
EN ISO 2560-A	AWS A5.1 / SFA-5.1	Welding positions	Polarity
E 42 0 RC 1 1	E6013		

Typical chemical composition, all weld metal, wt. %			
	C	Si	Mn
	0.09	0.35	0.5

Mechanical properties, all weld metal (single values typical)						
	Condition	Yield strength $R_{p0.2\%}$ MPa	Tensile strength R_m MPa	Elongation A ($L_0 = 5d_0$) %	CVN Impact toughness ISO-V KV J	
					20 °C	0 °C
	As welded	440 (≥ 420)	540 ($\geq 500 - 640$)	22 (≥ 20)	80	55 (≥ 47)

Steels to be welded	
EN	ASTM
S235JRG2 - S355J2; GS-38; GS-45; St35; St45; St35.8; boiler steels P235GH, P265GH, P295GH; ship building steels acc. to app.-grade 2; fine grained steels up to P355N; weldable ribbed reinforcing steel bars	ASTM A36 and A53 Gr. all; A106 Gr. A, B, C; A135 Gr. A, B; A283 Gr. A, B, C, D; A366; A285 Gr. A, B, C; A500 Gr. A, B, C; A570 Gr. 30, 33, 36, 40, 45; A607 Gr. 45; A668 Gr. A, B; A907 Gr. 30, 33, 36, 40; A935 Gr. 45; A936 Gr. 50; API 5 L Gr. B, X42-X52

Approvals
TÜV (00425), DB (10.014.86), DNV, CE

Carton Packaging	
	Weight: ~ 4.1 kg Diameter 2.0 x 250 mm 2.5 x 250 mm 2.5 x 350 mm 3.2 x 350 mm 4.0 x 350 mm 4.0 x 450 mm 5.0 x 450 mm