

# Selectarc 54

Rutile Electrode  
Nice appearance



## Montano

Allt inom stål & smide  
www.montano.se

### Classification

AWS A5.1	E6013	EN 499	E 42 0 RR 1 2
ISO 2560-A	E 42 0 RR 1 2		

### Description & Applications

Heavy coated rutile electrode for general use. Especially recommended for downhand welding, for fillet welds and vertical up position. Soft arc, few spatters, self lifting slag, excellent bead appearance.

Main applications: Currently used for welding mechanical constructions, shipbuilding, blacksmithing, boiler making...

### Construction steels for general use, tube steels, ship steels

<b>EN- Designation</b>	S185 - S355	L210 - L360	P235 - P355
<b>Ship steels</b>	Quality A & B		
<b>ASTM</b>	A285 grade C	A414 grade C, D, E, F	A442 grade 55, 60 A515 grade 55, 60

### Typical Wld metal Composition (%)

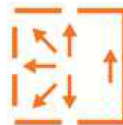
<b>C</b>	<b>Si</b>	<b>Mn</b>	<b>P</b>	<b>S</b>	<b>Fe</b>
<0,10	0,4	0,6	<0,025	<0,025	Rem.

### All Weld Metal Mechanical Properties

<b>R<sub>e</sub> (MPa)</b>	<b>R<sub>m</sub> (MPa)</b>	<b>A<sub>5</sub> (%)</b>	<b>KV (J)</b>	<b>KV (J)</b>	<b>KV (J)</b>
>400	510-580	>22	+ 20°C >64	+/- 0°C >47	- 20°C >28

### Welding Current & Instructions

<b>Dim. Ø</b>	<b>2,0</b>	<b>2,5</b>	<b>3,2</b>	<b>4,0</b>	<b>5,0</b>
(A)	55	70	115	150	180



= -	~ 45V
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www.fsh-welding.com www.montano.se