

## OK 43.39



Easy to use rutile electrode for welding in all positions except vertical down. Good slag detachability.

<b>Classifications</b>	SFA/AWS A5.1 : E6013 EN ISO 2560-A : E 42 0 RR 12
<b>Approvals</b>	CE EN13479 VdTUV 18801

Approvals are based on factory location. Please contact ESAB for more information.

<b>Welding Current</b>	AC, DC+-
<b>Alloy Type</b>	Carbon Steel
<b>Coating Type</b>	Rutile

### Deposition Data

Diameter	Current	Voltage	Number of electrodes/ kg weld metal	Fusion time per electrode at 90% I max	Deposition Efficiency %	Deposition Rate @ 90% I max
2.0 x 300.0 mm	50-80 A	23 V	167	36 sec	54 %	0.6 kg/h
2.5 x 300.0 mm	50-110 A	25 V	108	42 sec	54 %	0.8 kg/h
2.5 x 350.0 mm	50-110 A	25 V	88	46 sec	54 %	0.9 kg/h
3.2 x 450.0 mm	80-140 A	26 V	40.5	74 sec	54 %	1.3 kg/h
4.0 x 450.0 mm	120-210 A	27 V	27	76 sec	54 %	1.9 kg/h
5.0 x 450.0 mm	170-290 A	26 V	17	87 sec	56 %	2.5 kg/h