

509 Strongset Kit

A rutile coated mild steel electrode for welding in all positions except vertical down. Because of its good weldability SE is ideal as the general-purpose electrode where an appreciable proportion of the mild steel welding is positional also in difficult situations such as bridging wide gaps, corner welds etc. The electrode has a stable arc, produces negligible spatters and welds with an excellent appearance. An electrode for welding mild steel fabrication work in the shop or on site repair- and pipe work and in the shipbuilding industry. Easy striking and re-striking. An ideal electrode for making tack welds.

Specifications

Classifications	SFA/AWS A5.1 : E6013 EN ISO 2560-A : E 38 0 RC 11
Welding Current	AC, DC+-
Alloy Type	Carbon Manganese
Coating Type	Rutile

Deposition Data

Diameter	Current	Voltage	Deposition Efficiency (%)	Number of electrodes/kg weld metal	Burn-off Time /Electrode	Deposition Rate @ 90% I max
2.5 x 350.0 mm (0.098 x 13.8 in.)	60-100 A	22 V	65 %	86	50 sec	0.8 kg/h (1.8 lbs/h)
3.2 x 350.0 mm (1/8 x 13.8 in.)	80-150 A	22 V	65 %	53	57 sec	1.3 kg/h (2.9 lbs/h)
4.0 x 350.0 mm (5/32 x 13.8 in.)	100-200 A	22 V	60 %	39.0	65 sec	1.6 kg/h (3.5 lbs/h)
5.0 x 350.0 mm (0.197 x 13.8 in.)	150-290 A	24 V	60 %	24	87 sec	2.3 kg/h (5.1 lbs/h)