

Vodex

A high quality rutile electrode, specially designed for horizontal, vertical and overhead welding of mild steel plate and pipe.

Specifications	
Classifications	SFA/AWS A5.1 : E6013 EN ISO 2560-A : E 35 2 R 12
Approvals	ABS : 3 BV : 3 CE : EN 13479 DNV : 3 GL : 3 LR : 3Y

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

Welding Current	AC, DC+-
Alloy Type	Carbon Manganese
Coating Type	Rutile covering

Deposition Data					
Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.0 x 350.0 mm	40-70 A	22.8 V	54 %	58 sec	0.41 kg/h
2.5 x 350.0 mm	75-100 A	21.1 V	60 %	52 sec	0.73 kg/h
3.2 x 450.0 mm	95-125 A	19.5 V	68 %	81 sec	1.1 kg/h
4.0 x 450.0 mm	135-180 A	21 V	65 %	87 sec	1.5 kg/h
5.0 x 450.0 mm	155-230 A	19.9 V	66 %	102 sec	2.03 kg/h