

OK 43.39

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

Specifications	
Classifications	SFA/AWS A5.1 : E6013 EN ISO 2560-A : E 42 0 RR 12
Approvals	CE : EN13479 UKCA : EN13479

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

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

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	460 MPa	520 MPa	27 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
ISO		
As Welded	0 °C	60 J

Typical Weld Metal Analysis %		
C	Mn	Si
0.07	0.5	0.35

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