

Phoenix Sh Gelb R

Stick electrode

Classifications

unalloyed rutile

EN ISO 2560-A:

AWS A5.1:

E 38 2 RB 12

E6013

Characteristics and field of use

Rutile basic electrode. Excellent vertical up welding characteristics; easy handling in out of position work; particularly suitable for fabricating radiographically sound circumferential pipe welds; good porosity-free root weld fusion, also in tight air gaps. Useable in pipeline, boiler and tank construction, structural steel work and shipbuilding.

Base materials

S235JRG2 - S355J2; shipbuilding steels appr.-grade 3; boiler steels P235GH, P265GH, P295GH; ASTM A36 and A53 Gr. all; A106 Gr. A, B, C; A135 Gr. A, B; A283 Gr. A, B, C, D; A366; A285 Gr. A, B, C; A500 Gr. A, B, C; A570 Gr. 30, 33, 36, 40, 45; A607 Gr. 45; A668 Gr. A, B; A907 Gr. 30, 33, 36, 40; A935 Gr. 45; A936 Gr. 50; API 5 L Gr. B, X42-X52

Typical analysis of all-weld metal (Wt-%)

C

Si

Mn

0.08

0.20

0.55

Mechanical properties of all-weld metal

Heat Treatment	Yield strength 0.2%	Tensile strength	Elongation (L ₀ =5 ₀)	Impact values ISO-V
	MPa	MPa	%	+20°C
untreated	380	460	22	75

Operating data



Polarity = - / ~

Dimensions (mm)

Amperage A

2.0 x 250

30- 75

2.5 x 250

40- 90

2.5 x 350

40- 90

3.2 x 350

90-130

4.0 x 350

140-190

4.0 x 450

140-190

5.0 x 450

190-250

Approvals and certificates

TÜV (01591.), DB (10.132.20), ABS, BV, GL, LR, DNV