



**MANUFACTURERS OF A DIVERSE RANGE OF
ADVANCED WELDING CONSUMABLES**

**SECTION
3**

WI-0304 DS7 RD-260 Rev. 0, Date 01.09.2008

RD-260	AN EXCEPTIONALLY VERSATILE RUTILE MEDIUM CELLULOSE FLUX COATED MILD STEEL ELECTRODE FOR ALL POSITIONAL WELDING					DATA SHEET NO. 7					
	SPECIFICATION	AWS A5.1	BS EN ISO 2560-B	JIS Z 3211							
CLASSIFICATION	E6013	E4313	D4313								
PRODUCT DESCRIPTION	The design emphasis of the flux is engineered to produce a fluid but quick freezing slag so facilitating all positional welding including vertical down. The balanced rutile, cellulosic flux containing both alloying and deoxidizing elements is extruded on to a mild steel wire with a blend of silicates that ensures coating strength and stability.										
WELDING FEATURES OF THE ELECTRODE	The electrode welds with a smooth stable arc on both AC and DC. Spatter is minimal. Weld seams are smooth, bright and evenly rippled. Initial arc strike and re-strike are instant. For flat and vertical down welding use amperages towards the top end and for vertical up and overhead towards the bottom of range. Slag detachability is excellent and metal recovery is some 98% with respect to weight of core wire.										
APPLICATIONS AND MATERIALS TO BE WELDED	All positional welding of structural steels of the following and related steel specifications: Mild and medium carbon-manganese steels up to 15mm thick with a UTS of 500N/mm ² max. Typical grades : BS 1449 plate and sheet, BS 4360 grades 43A and 43C, Lloyds A & D ship steel BS 4360 grade 50B Lloyds grades AH and DH, BS 3059 and BS 3601 grade 320-410 API5L A-B and X42.										
WELD METAL ANALYSIS COMPOSITION % BY Wt.		C	Mn	Si	S	P	Cr	Ni	Mo	V	Fe
	MIN	-	-	-	-	-	-	-	-	-	
	MAX	0.2	1.2	1.0	-	-	0.2	0.3	0.3	0.08	
	TYPICAL	0.08	0.5	0.3	0.02	0.02	0.03	0.04	0.01	0.01	Bal.
WELD METAL PROPERTIES (ALL WELD METAL)	PROPERTY	UNITS	MINIMUM	TYPICAL	OTHERS						
	Tensile strength	N/mm ²	430	520							
	0.2% Proof stress	N/mm ²	330	430							
	Elongation on 4d	%	17	28							
	Reduction of Area (RA)	%	-	70							
	Impact energy 0°C	J	-	80							
WELDING AMPERAGE AC or DC	Ø (mm)	2.0	2.6	3.2	4.0	5.0					
	MIN	30	60	80	120	160					
	MAX	80	110	140	190	230					
OTHER DATA	Electrodes that have become damp should be re-dried at 110°C for 1 hour.										
APPROVED BY	LR; ABS; DNV; BKI - Grade 2										