

SUPERTIT FIN is a rutile medium coated electrode, especially developed for welding mild steel for light metallic constructions and thin sheet.

Suitable for trade, use in structural engineering, shipbuilding, vehicle and agricultural machines, made of steel with max. 0,25%C, for service temperature up to 0C, like: S185, S (P)235, S275, S (P)355, P265, P295.

Excelent striking and restriking qualities. Electrodes welds with a stabile arc and very spattering loss. The slag is self-releasing. Very good weldability on AC and DC- current.

Classification	
EN ISO	2560-A: E 42 0 R 12
AWS	A5.1: E 6013

Approvals						
ABS	BD	BV	DNV	GL	LRS	TÜV
2		2HH	2	2YH15	2YmH5	●

CE

Chemical analysis (Typical values in %)

	C	Mn	Si	P	S
All weld metal	0.08	0.5	0.4	≤0.03	≤0.02

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Impact Energy ISO - V (J)
				0 °C
As Welded	430-470	490-600	≥ 24	≥ 47

Materials

SA 516 gr.60; SA 516 gr.70; SA 106 gr.B

S(P)235-S(P)420, GP240-GP280, L245-L360

S(P)235 si S(P)355; GP240; GP280

Storage

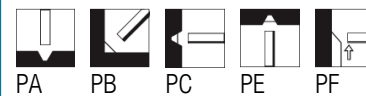
Keep dry and avoid condensation.

Re-drying not generally required.

If necessary 100°-110°C for 1 hour, max. 3 times.

Current condition and welding position

AC; DC-



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	CBOH		CBOX	
				PC	Code	PC	Code
1.6	260	35-50	5.90	250	W000380868		
2.0	300	50-70	11.80	161	W000380870		
2.5	300	60-90	16.03			237	W000288259
2.5	350	60-90	31.90			-	W000288260
3.2	350	110-135	31.91			141	W000288261
3.2	450	110-135	41.73			139	W000288262
4.0	350	160-180	48.39			93	W000288263
4.0	450	160-180	64.44			90	W000288264
5.0	450	180-210	96.77			62	W000288265