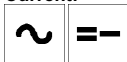


Coating type:

Rutile

Current:



Welding positions:



Arc voltage: 42V

Approvals: ABS, BV, DB+Ü, DNV, GL, LR, TÜV

Tip colour:
Red

Printing:

HILCO Red Extra / E42 0 RC / E 6013

Red Extra is our universal electrode for all welding positions, including vertical-down position. The electrode is characterised by easy handling, smooth arc transfer, easy slag removal and a finely rippled bead surface. Red Extra is the ideal choice for construction work where the use of one type of electrodes is permissible. Typical applications include assembly, workshop and repair welding of mild and low-alloyed structural steels. Red Extra is an all-current type (AC/DC), which also operates on transformers with low OCV, min. 42V.

Base materials to be welded:

- Ships plate A-D, A(H)32-D(H)36, S315G1S-S355G3S
- Structural steel S185-S355J2, St.33-St.52, C(K)10-C(K)35
- Boiler steel P235GH-P295GH, HI, HII, 17Mn4
- Fine grain steel P275N-P355N, S275N-S355M, StE285-StE 355, StE285-StE355TM
- Pipe steel P235T1-P355N, L210-L360NB, St37.0-St52, St45.8, X42-X52, StE210.7-StE360.7TM
- Cast steel GP240R, GS45

Applications:

- Shipyards/offshore
- Construction works
- Bridge & road constructions
- Pressure vessel & boiler industry
- Repair Shops
- Office furniture industry

Equivalent product in alternative welding process:

SMAW	GMAW	FCAW	GTAW	SAW	Gas welding / brazing
-	K 60	Hilcord 40	Fer SG 2	H60 / HW430	Fer G 1

Chemical composition, wt. % weld metal – typical:

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb	V	Al
0,12	0,60	0,40	≤ 0,030	≤ 0,030							

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 420	≥ 500	≥ 22	0°C ≥ 50

Packaging and welding data:

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
2,0	300	10,5	40-60
2,5	350	18,2	60-100
3,2	350	28,9	90-140
4,0	350	44,6	150-190
5,0	350	70,4	180-240