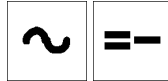


**Coating type:**

Rutile

**Arc voltage:** 42V

**Current:**



**Tip colour:**

-

**Welding positions:**



**Printing:**

HILCO Red / E 6013

Red is our rutile coated 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 is selected in a wide range of sheet metal applications. Typical applications include tack welding and welding on galvanised, primer painted and slightly rusted plates. Red is an all-current type (AC/DC) and is suitable for welding 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:**

- Shipbuilding & Offshore
- General fabrication & construction
- Power Generation
- Repair & Maintenance

**Equivalent product in alternative welding process:**

SMAW	GMAW	FCAW	GTAW	SAW	Gas welding / brazing
-	K 60	Hilcord 40	Fer SG 1	H100 / HW430	Fer G 1

**Chemical composition, wt. % weld metal – typical:**

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb	V	Al
0,10	0,50	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 ≥ 47

**Packaging and welding data:**

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
2,5	350	17,5	60-90
3,2	350	28,6	90-140
4,0	350	45,1	150-190