

Manual Metal Arc Electrodes

General Purpose MMA Electrodes

Vodex



AWS A/SFA 5.1-91 E6013
EN 499 E 35 2 R 12
EN ISO 2560-A E 35 2 R 12

Description and applications

Vodex is a high quality rutile electrode, specially designed for horizontal, vertical and overhead welding of mild steel plate and pipe.

Approvals

ABS : 3 LR : 3, 3Y MOD : MS<25mm,
BV : 3 CE EN 13479 (Navy) B & BX <12mm
GL : 3

All-weld metal properties

Composition wt%

	Min	Max
C		0.10
Si	0.10	0.20
Mn	0.30	0.60
S		0.035
P		0.035

Mechanical

YS
UTS
Elongation

As-welded

375 min	N/mm ²
460-550	N/mm ²
24	%
Charpy V impact values	
at -10°C	61 min ave J
at -20°C	47 min ave J

Current range

AC (min OCV 50) or DC +/-

Size (mm)	2.0	2.5	3.2	4.0	5.0	6.0
Current (amps)	40-70	75-100	95-125	135-180	155-230	185-300