

Manual Metal Arc Electrodes

General Purpose MMA Electrodes

Vortic Marine



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

Description and applications

Vortic Marine is a high quality rutile-coated electrode for general fabrication and shipyard work in the downhand, vertical and overhead positions.

Approvals

ABS : 3 LR : 3, 3Y MOD : MS<25mm,
BV : 3 CE EN 13479 (Navy) B & BX <12mm
VdTÜV : 01698

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
Charpy V impact values

As-welded

375 min N/mm²
460-550 N/mm²
24 %
at -10°C 61 min ave J
at -20°C 47 min ave J

Current range AC (min OCV 50) or DC +/-

Size (mm)	2.5	3.2	4.0	5.0
Current (amps)	75-100	95-125	135-180	155-230