

## 1000 S

**CATEGORY** SMAW Stick Electrodes

**TYPE** Universal rutile electrode for all positions

**APPLICATIONS** Trucks, trailers, wagons, shipbuilding, yacht building, root runs in pipe welding, repair welding etc.

**PROPERTIES** 1000 S is a medium thick coated electrode suitable for general construction and offers a very smooth seam surface. 1000 S is suitable for all positions; 2,5 mm can even be used in vertical down position. Medium fast freezing weld metal makes this electrode excellently suitable for root runs in vertical up position in pipe welding. The slag is self detaching and the special blue coating was developed to offer high resistance against moisture pick up.

**CLASSIFICATION**

AWS	A 5.1: E 6013
EN ISO	2560-A: E 42 0 RC 11
DIN	1913: E 51 32 RR(C)5

**SUITABLE FOR**

DIN:	-	W.Nr.:	
Unalloyed steels:	St 33 to St 52.3		1.0035 to 1.0570
Boiler plates:	Hl, Hll, 17 Mn4		1.0345, 1.0425, 1.0481
Pipe steels:	St 35 to St 52.4		1.0308 to 1.0581
-	StE 210.7 to StE 360.7		1.0307 to 1.0582
Shipbuilding plates:	A, B, D		1.0440, 1.0472, 1.0475
Steel castings:	GS-38 to GS-52		1.0416 to 1.0551
Thin sheets:	1623/1		

**APPROVALS** TUV, DB, GL, CE approved

**WELDING POSITIONS:**



**ALL WELD METAL ANALYSIS**

C	Mn	Si	Cr	Ni	Mo
0,08	0,65	0,45			

**MECHANICAL PROPERTIES**

Heat Treatment	RP0,2 (N/mm2)	Rm (N/mm2)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				0°C	-40°C	-60°C	
AW	>420	510-610	>22	>47			

AW: as welded

**WELDING PARAMETERS PACKING**

D (mm)	Welding Parameters			Packing		
	Length (mm)	Current (A)	kg / can	kg / 6pack	kg / 1000	
2,5	350	60-85	2.6	15.6		
3,2	350	90-135	2.6	15.6		
4,0	350	130-170	2.6	15.6		
5,0	350	175-220	2.6	15.6		

**REDRYING TEMPERATURE** 140°C / 1hr

**NOTE** on request also available in 1,6 and 2,0 mm