

**Pantafix®**

## CLASSIFICATION

AWS A5.1 : E6013  
 ISO 2560-A : E 38 0 RC 11

## GENERAL DESCRIPTION

Rutile general purpose, all position electrode, including vertical down  
 Soft arc therefore suitable for relative thin plates and bridging wide gaps  
 Excellent in pipe welding and construction  
 Good start and restart behaviour  
 Also weldable with low Open Circuit Voltage transformers (min. OCV 42V)  
 Good X-ray soundness

## WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PG/3Gd



PE/4G



PH/5Gu



PJ/5Gd

## CURRENT TYPE

AC / DC -

## APPROVALS

TÜV

+

## CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Mn	Si
0.09	0.5	0.4

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Condition	Yield strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Impact ISO-V(I) 0°C
Required: AWS A5.1 ISO 2560-A Typical values	min. 330 min. 380 500	min. 430 470-600 540	min. 17 min. 20 24	not required min. 47 60

## PACKAGING AND AVAILABLE SIZES

	Diameter (mm)	2.0	2.5	3.2	4.0
Length (mm)		300	350	350	350
Units/ Carton box	Pieces / unit	235	145	155	120
	Net weight/unit (kg)	2.4	2.8	4.8	5.4

Identification Imprint: 6013 / PANTAFIX Tip Color: none

Pantafix®: rev. EN 25

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## EXAMPLES OF MATERIALS TO BE WELDED

Steel grades/Code	Type
<b>General structural steels</b>	
EN 10025	S185, S235, S275
<b>Ship plates</b>	
ASTM A 131	Grade A, B, D
<b>Cast steels</b>	
EN 10213-2	GP240R
<b>Pipe material</b>	
EN 10208-1	L210, L240, L290
EN 10208-2	L240, L290
API 5LX	X42, X46
EN 10216-1/EN10217-1	P235, P275
<b>Boiler &amp; pressure vessel steel</b>	
EN 10028-2	P235, P265, P295
<b>Fine grained steels</b>	
EN 10025 part 3	S275
EN 10025 part 4	S275

## CALCULATION DATA

Diam. x length (mm)	Current range (A)	Current type	Arc time	Energy	Dep. rate	Weight/ 1000 pcs (kg)	Electrodes/ kg weldmetal B	kg electrodes/ kg weldmetal 1/N
			[S]*	- per electrode at max. current - E(kJ)	H(kg/h)			
2.0x300	40-75	AC	41	58	0.5	10.4	178	1.98
2.5x350	50-90	AC	60	130	0.7	17.8	88	1.57
3.2x350	70-130	AC	66	206	1.0	29.5	53	1.58
4.0x350	130-175	AC	72	333	1.3	43.6	37	1.61

\*Stub end 35mm

## WELDING PARAMETERS, OPTIMUM FILL PASSES

Diameter (mm)	Welding positions					
	PA/1G	PB/2F	PC/2G	PF/3G up	PG/3G down	PE/4G
2.5	80A	75A	75A	75A	75A	75A
3.2	120A	115A	125A	115A	125A	115A
4.0	175A	165A	160A	160A	170A	160A

## REMARKS / APPLICATION ADVICE

Vertical down only applicable for "clean" structural steel