



# HILCO RED EXTRA

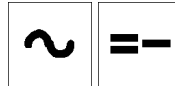
Stick electrode – unalloyed steel

AWS A5.1: E 6013

EN ISO 2560-A: E 42 0 RC 11

**Coating type:**  
Rutile

**Current:**



**Welding positions:**



Red Extra is our universal electrode for all welding positions, including vertical-down position. This electrode is characterised by easy handling, smooth arc transfer, easy slag removal and a finely rippled bead surface. Red Extra is the ideal choice for construction work where the use of one type of electrode is permissible. Typical applications include assembly, workshop and repair welding of mild and low-alloyed structural steels. Red Extra is an all-current type (AC/DC), which also operates 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

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

C	Mn	Si	S	P
0,09	0,5	0,4	0,005	0,015

**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	≥ 510	≥ 22	0°C ≥ 47 20°C ≥ 47

**Packaging and welding data:**

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
2,0	300	10,5	40-60
2,5	350	18,2	60-100
3,2	350	28,9	90-140
4,0	350	44,2	150-190
5,0	350	70,4	180-240