



# HILCO VELVETA

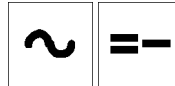
Stick electrodes – unalloyed steel

AWS A5.1: E 6013

EN ISO 2560-A: E 42 0 RR 32

**Coating type:**  
Rutile

**Current:**



**Welding positions:**



Velveta is our rutile coated electrode for all welding positions, especially for vertical up position. This electrode is characterised by an extremely easy handling, smooth arc transfer, easy slag removal and a finely rippled bead surface. Velveta is the logic first choice for thin-walled pipe welding. Typical applications include assembly, workshop and repair welding of mild and low-alloyed structural steels. Velveta 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
- Oil & Gas Industry

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

| C    | Mn   | Si   | S     | P     |
|------|------|------|-------|-------|
| 0,08 | 0,40 | 0,40 | 0,008 | 0,013 |

### Mechanical properties, weld metal – typical:

| Condition | 0,2% Yield strength<br>MPa | Tensile strength<br>MPa | Elongation<br>Lo=5d - % | Impact Values<br>ISO-V J |
|-----------|----------------------------|-------------------------|-------------------------|--------------------------|
| As welded | ≥ 420                      | ≥ 510                   | ≥ 22                    | 0°C ≥ 47<br>20°C ≥ 50    |

### Packaging and welding data:

| Dia.<br>mm. | Length<br>mm. | Weight (kgs)<br>1000 pcs. | Current<br>A |
|-------------|---------------|---------------------------|--------------|
| 2,0         | 300           | 10,0                      | 50-70        |
| 2,5         | 350           | 19,2                      | 60-100       |
| 3,2         | 350           | 31,3                      | 80-140       |
| 4,0         | 350           | 46,0                      | 130-180      |
| 4,0         | 450           | 59,0                      | 130-180      |