

BLUCORD is a medium-coated rutile MMA electrode with a fast freezing slag. Universal all-positional electrode which is very easy to weld. Suitable for vertical down welding of thin plates.

Suitable for bad prepared joints and dirty sheets, with good penetration in groove. For trade, for all light constructional work, including pipework.

Good slag detachability and excellent bead appearance. Efficiency 100%. Operates on low open circuit voltage, recommended for tack welding or continuous welding. Very good weldability on AC and DC- current.

Rutile coated electrode suitable for carbon steel. Good weldability and mechanical properties.

Classification	
EN	2560-A: E 42 0 R 12
AWS	A5.1: E 6013

Approvals			
ABS	BV	DNV	LRS
2Y	2YH	2YH15	2YmH15

CE

Chemical analysis (Typical values in %)

	C	Mn	Si	P	S
All weld metal	0.08	0.6	0.40	0.025	0.010

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Impact Energy ISO - V (J)
				0 °C
As Welded	≥ 420	500-640	≥ 24	≥ 47

Materials

S(P)235 to S(P)355; GP240; GP280

Storage

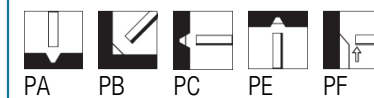
Keep dry and avoid condensation.

Re-drying not generally required.

If necessary 100°-110°C for 1 hour, max. 3 times.

Current condition and welding position

AC; DC-



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	CBOH		CBOX	
				PC	Code	PC	Code
1.6	250	35-50	5.90	250	W000380881		
2.0	300	50-70	11.80	161	W000380882		
2.5	300	60-90	17.67			215	W000380884
2.5	350	55-90	17.08			240	●
3.2	350	80-130	30.71			140	●
3.2	450	90-130	43.85			130	●
4.0	350	120-180	47.06			85	●
4.0	450	120-180	60.00			85	●