

Zodian Universal



A versatile rutile-cellulosic electrode for welding in all positions , including vertical down.

Specifications	
Classifications	SFA/AWS A5.1 : E6013 EN ISO 2560-A : E 38 0 RC 11
Approvals	BV : 2 CE : EN 13479 DNV : 2 LR : 2 UKCA : EN 13479

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	AC, DC+-
Alloy Type	C/Mn
Coating Type	Rutile-cellulosic covering
Min AC OCV	50 V

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	390 MPa	500 MPa	28 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
ISO		
As Welded	0 °C	60 J

Deposition Data					
Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350 mm	60-100 A	22 V	65 %	50 sec	0.8 kg/h
3.2 x 350 mm	80-150 A	22 V	65 %	57 sec	1.3 kg/h
4.0 x 350 mm	100-230 A	22 V	60 %	65 sec	1.6 kg/h
5.0 x 450 mm	150-290 A	24 V	60 %	114 sec	2.3 kg/h