

BLUCORD is a medium-coated rutile MMA electrode with a fast freezing slag. Universal all-positional electrode which is very easy to weld, for all light constructional work, including pipework. Suitable for vertical down welding of thin plates. Operates on low open circuit voltage, recommended for tack welding. Good slag detachability and excellent bead appearance. Efficiency 100%.

Classification	
EN ISO	2560-A: E 42 0 R 12
AWS	A5.1: E 6013
GOST	9467-75:E50-E51 1

Approvals				
ABS	ANR	BV	DNV	LRS
2Y	2Y H	2Y H	2YH15	2Ym

CE

Chemical analysis (Typical values in %)

	C	Mn	Si	P	S
All weld metal	0.07	0.50	0.40	≤ 0.03	≤ 0.02

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	≥ 430	510-550	≥ 24	≥ 47	

Materials

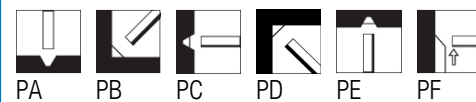
S(P)235 to S(P)355; GP240; GP280

Storage

Keep dry and avoid condensation. Re-drying not generally required. If necessary: 100-110 °C for 1 hour.

Current condition and welding position

AC; DC-



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	CBOX	
				PC	Code
1.6	250	20-35	5.7	600	●
2.0	300	40-60	10.5	360	●
2.5	300	65-90	16.8	230	●
2.5	350	65-90	20.1	220	●
3.2	350	100-140	32.4	140	●
3.2	450	100-140	42.0	140	●
4.0	350	140-180	47.4	95	●
4.0	450	140-180	62.1	95	●
5.0	450	170-230	92.9	70	●
6.0	450	200-260	133.3	45	●