

Classifications

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|--------------------|---------------|------------|---------|
| EN ISO 2560-A:2006 | : E 38 0 R 11 | KS D 7004 | : E4313 |
| EN ISO 2560-B:2006 | : E 43 13 A | JIS Z 3211 | : E4313 |
| AWS A5.1-04 | : E6013 | | |

Description

- Covering is high titania type for welding of all kinds of light constructional work in all positions, including pipe welding.
- Excellent striking and restriking properties.
- Excellent slag removal and bead appearance without undercut.
- Redry the electrode at 70~100°C for 30~60 minutes prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

| C | Si | Mn | P | S | Ni | Cr | Mo | V |
|------|------|------|-------|-------|------|------|------|------|
| 0.06 | 0.35 | 0.40 | 0.020 | 0.011 | 0.02 | 0.03 | 0.01 | 0.01 |

Typical mechanical properties of all-weld metal

| | Y.S (MPa) | T.S (MPa) | El. (%) | IV (J) | | Remarks |
|---------------|--------------|--------------|------------|--------|------|---------|
| | | | | RT | 0°C | |
| AWS A5.1 | min. 330 | min. 430 | min. 17 | | | |
| EN ISO 2560-A | min. 380 | 470~600 | min. 20 | | ≥ 47 | |
| Example | 430 | 490 | 28 | 75 | 60 | AW |

* AW : As-Welded

Sizes available and recommended currents (AC or DC +)

| Dia. | (mm) | 2.6 | 3.2 | 4.0 | 5.0 | 6.0 |
|-------------|-------------|-----------------|------------------|-------------------|--------------------|---------|
| Length | (mm) | 350 | 350 | 400 | 400 | 450 |
| Amp. (A) | F V · OH | 60~100 60~90 | 80~130 80~110 | 130~180 90~140 | 160~220 120~190 | 210~280 |

Approvals

| ABS | BV | DNV | GL | KR | LR | NK |
|-----|----|-----|----|----|----|------|
| 2 | 2 | 2 | 2 | 2 | 2m | KMW2 |

* Others : KS, JIS, CE