

Standards

AWS A5.1 : E 6013

**Chemical Composition of
Weld Metal % (Typical)**

C	Si	Mn
0.05	0.1	0.15

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength			Elongation (Lo=5do) (%)
		(ISO-V/-20°C)	(ISO-V/0°C)	(ISO-V/+20°C)	
390	510	-	55-65	60-70	min.22

*Single values are minimum

Typical Base Material Grades
Features and Applications

- Medium-thickness rutile covered electrode.
- Easy Slag Removal
- Good Welding Beads
- Excellent re-strike capability

Welding Positions

Current Type

D.C.(-) / A.C.

Operating Data

Diameter x Length (mm) / (inch)	Welding Current (A)	Weight g / 100 pcs
2,50 x 350	70 - 110	1850
3,20 x 350	110 - 140	2940
4,00 x 350	140 - 180	4430