

Standards

AWS A5.35: UWE6013-2A

Chemical Composition of Weld Metal % (Typical)

C	Si	Mn
0,07	0,35	0,55

Mechanical Properties (Typical)

Conditions	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V) (Joule) (0°C)	Elongation ((L ₀ =5d ₀) (%))
Level2	min. 320	min 430	min. 40	min. 6
Wet	428	494	50	7

Typical Base Material Grades

- Mild Steels, Carbon Steels

Features and Applications

- Rutile covered welding electrode designed for general underwater wet welding applications up to 20m water depth.
- Preferred for temporary maintenance and repair works .
- Simple to use in all positions in fresh and salt water.
- Waterproof coating prevent the solubility of the hydrogen from the water to weld metal and provides diver's safety.
- Good root and sidewall penetration and overhead fusion properties.
- Easy to strike and re-strike.
- Best at weld metal deposition rate.
- Slag removal is more easy. No needed for extra surface cleaning.

Welding Positions



Current Type

D.C. (-) or D.C. (+)

Operating Data

Product Code	Diameter x Length (mm)	Welding Current (A)	Weight g / 100 pcs
3030100112	Ø 3,2 x 350	140-180	3120
3030100113	Ø 4,0 x 350	160-210	4580