

Covered electrode

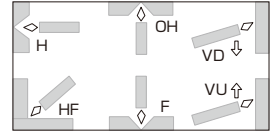
Classification: ASME / AWS A 5.1 E6013
EN ISO 2560-A-E 35 0 R

Features: ▪ Suitable for butt and fillet welding of thin plates
▪ Excellent usability in all positions including vertical downward

Type of covering: High titania

Redrying Conditions: 70~100°Cx0.5~1h

Identification color: 1st Black, 2nd -

Welding Positions:**Chemical composition of all-weld metal (%) as per AWS**

	C	Si	Mn	P	S
Example	0.08	0.30	0.37	0.012	0.010
Guaranty	0.05~0.12	0.15~0.45	0.25~0.65	≤0.030	≤0.025

Mechanical properties of all-weld metal as per AWS

	YP (MPa)	TS (MPa)	EI (%)
Example	450	510	25
Guaranty	≥330	≥410	≥17

Recommended welding parameters

	2.0mm	2.6mm	3.2mm	4.0mm	5.0mm
F, HF, H, VD	30~65A	45~95A	60~125A	105~170A	150~220A
VU, OH	30~65A	45~95A	60~125A	100~150A	125~190A

Polarity

Example	AC
Guaranty	AC, DC-EP, DC-EN

Approvals

ABS	LR	NK
2	2m	KMW2

Packages

Dia. (mm)	Length (mm)	Weight per pack (kg)	Weight per carton (kg)	Weight per piece (g)
2.0	300	2	20	10
2.6	350	5	20	19
3.2	350	5	20	29
4.0	400	5	20	53
5.0	400	5	20	81