

Classifications

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