S-6013.LF

Type : Rutile

CE

Conformances

AWS A5.1/ ASME SFA5.1 E6013
JIS Z3211 E4313
EN ISO 2560-A-E38 0 R 1 2
KR 2
ABS 2
LR 2
BV 2
DNV·GL 2
NK KMW2
CE

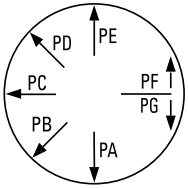
Applications

- General fabrication

Features

- Suitable for butt and fillet welding of thin plates
- Good restriking
- Good bead appearance
- Easy to remove slag
- Smooth arc and low fume
- AC welding with low ocv

Welding Position



Current

AC or DC +

Redrying Conditions

70~100°C (158~212°F) X 0.5~1hr

Diameter / Packaging

Diameter	Length	Standard	
mm (in)	mm (in)	packet 5kg(11lbs)	carton 20kg(44lbs)
2.6 (3/32)	350 (14)	√	
3.2 (1/8)	350 (14)	√	
4.0 (5/32)	400 (16)	√	
4.0 (5/32)	450 (18)	√	
5.0 (3/16)	400 (16)	√	
5.0 (3/16)	450 (18)	√	
6.0 (15/64)	450 (18)	√	

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.05	0.23	0.35	0.022	0.017

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in²)	TS MPa(lbs/in²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft·lbs)
439 (63,700)	488 (70,900)	26.8	0 (32)	67 (50)

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)	6.0 (15/64)
Length mm (in)	350 (14)	350 (14)	400 (16) 450 (18)	400 (16) 450 (18)	450 (18)
F & HF	50~95	80~130	120~180	160~230	220~300
V-up, OH	45~90	60~120	100~160	120~220	-