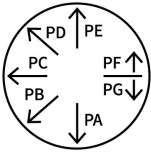


S-6013.LF

Classification

AWS A5.1/ASME SFA-5.1 E6013
JIS Z 3211 E4313
EN ISO 2560-A E38 0 R 1 2
KS D7004 E4313

Welding Positions



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

Polarity

AC or DC +

Application Areas

- General fabrication

Redrying Conditions

70~100°C (158~212°F) X 0.5~1hr

Approvals

ABS	BV	DNV	KR	LR	NK	CE
✓	✓	✓	✓	✓	✓	✓

Typical Chemical Composition of All-Weld Metal (wt%)

C	Si	Mn	P	S
0.06	0.26	0.34	0.020	0.011

Typical Mechanical Properties of All-Weld Metal

Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
418(61)	497(72)	26	0(32)	57(42)

SMW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	V-up, OH	Packaging
2.6(3/32)	350(14)	55-95	45-90	Standard/Vacuum - Packet 5kg (11lbs), Carton 20kg (44lbs)
3.2(1/8)	350(14)	80-130	60-120	
4.0(5/32)	400(16)/450(18)	120-180	100-160	
5.0(3/16)	400(16)/450(18)	160-260	120-200	
6.0(15/64)	450(18)	220-300	-	

SMAW

GMAW

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Metal-cored Wire

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SAW Flux