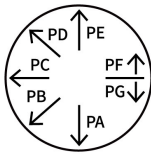


S-6013.V

Classification

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

Welding Positions



Features

- Suitable for butt and fillet welding of thin plates
- Good at vertical down
- Good bead appearance
- Good restriking
- Easy to remove slag

Polarity

AC or DC ±

Application Areas

- General fabrication

Redrying Conditions

70~100°C (158~212°F) X 0.5~1hr

Approvals

ABS	KR	LR	NK	CWB	CE	DB	TUV
✓	✓	✓	✓	✓	✓	✓	✓

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

C	Si	Mn	P	S
0.06	0.29	0.47	0.019	0.010

Typical Mechanical Properties of All-Weld Metal

Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft · lbs)
411(60)	481(70)	27	0(32)	60(44)

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)	160-230	120-200	
6.0(15/64)	450(18)	220-300	-	

SMAW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux