

AK E6013

GB/T 5117 E4313

AWS A5.1 E6013

EN ISO 2560-A:E 35AR 12

Description: It is a rutile electrode for all positional welding, with a good weld appearance on both butt and fillet welds for the good flowing properties of the weld metal. Good slag detachability and low spatter. It can still keep a stable arc even at low welding currents, making the electrode suitable for sheet metal welding.

Application: Used to weld low carbon steel structures, particularly suitable for sheet steel and short weld welding.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Mo	Cr	V
Requirement	0.20	1.0	1.2	0.035	0.040	0.30	0.30	0.20	0.08
Actual Result	0.08	0.21	0.43	0.021	0.026	0.04	0.007	0.011	0.009

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact values (J)
Requirement	≥430	≥ 330	≥ 17	≥47J(-20℃)
Actual Result	490	396	26	82

Recommended welding parameters:

Diameter/ mm		2.5	3.2	4.0
Welding current/A	F/ H	60-90	80- 130	150- 190
	V/OH	50-80	80- 110	130- 170