

SMAW Electrodes

NK32

AWS A5.1M E4313 / A5.1 E6013 (Similar)
JIS Z 3211 E4303
ISO 2560-A-E 35 2 R

Product Features:

- Lime titanium oxide type covered electrodes for mild steel.
- Easy slag removal and re-arcing property.
- High current available for increasing welding efficiency.
- Superior for flat and fillet horizontal position.

Applications:

- Suitable for moderate thickness steel structures such as shipbuilding, truck frame, buildings, bridges, tanks, and other general structures.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	P	S	Fe
0.07	0.28	0.42	0.025	0.009	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value	
			(0°C) J	(-20°C) J
426	504	28	74	58

Size (mm) & recommended welding parameters (A) AC or DC±

Diameter / Length	2.6/300	3.2/350	4.0/400/450	5.0/450
Flat position	80~100	100~140	160~200	200~260
Vertical / overhead position	70~90	90~130	140~180	160~200

Note:

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