

SMAW Electrodes

K120

AWS A5.1M E4313 / A5.1 E6013
JIS Z 3211 E4313
ISO 2560-A-E 35 0 R

Product Features:

- High titanium oxide type covered electrode for mild steel.
- High arc stability and easy to re-arc.
- Easy slag removal in proper current range.
- Good bead appearance.
- High welding performance and no undercut occurred.

Applications:

- Suitable for low current thin plates welding.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	P	S	Fe
0.09	0.39	0.46	0.021	0.008	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (0°C) J
460	510	25	71

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

Diameter / Length	2.0/300	2.6/300	3.2/350	4.0/400
Flat position	50~70	60~90	100~130	150~180
Vertical / overhead position	45~60	60~70	90~120	130~160

Note:

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