

SMAW Electrodes

G13

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.
- Higher speed fusion rate to improve deposition efficiency than other similar grade products.
- High current available for increasing welding efficiency.

Applications:

- Suitable for thin plates, light structure, vehicles and general iron fittings.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	P	S	Fe
0.08	0.28	0.39	0.021	0.014	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (0°C) J
434	496	22	64

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

Diameter / Length	2.6/350	3.2/350	4.0/400	5.0/450	6.0/450
Flat position	60~90	100~130	150~180	200~240	240~310
Vertical / overhead position	60~70	90~120	130~160	150~190	-

Note:

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