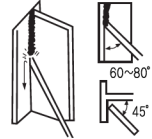


Classifications

EN ISO 2560-A:2006	: E 38 0 R 15	KS D 7004	: E4313
EN ISO 2560-B:2006	: E 43 13 A	JIS Z 3211	: E4313
AWS A5.1-04	: E6013		

Description

- Welding of shells of railway vehicles, cars and other steel sheet structures and general light structural steels.
- In vertical-down welding, excellent bead appearance can be obtained by taking a little bit higher welding amperage and holding the electrode at the illustrated angles.
- Welding under excessive amperage conditions can cause the deterioration of radiographic soundness.
- Redry the electrode at 70~100°C for 30~60 minutes prior to use.

**Welding positions****Typical chemical composition of all-weld metal (%)**

C	Si	Mn	P	S	Ni	Cr	Mo	V
0.09	0.38	0.49	0.020	0.013	0.02	0.03	0.01	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				RT	0°C	
AWS A5.1	min. 330	min. 430	min. 17			
EN ISO 2560-A	min. 380	470~600	min. 20		≥ 47	
Example	420	490	29	65	50	AW

* AW : As-Welded

Sizes available and recommended currents (AC or DC +/-)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	350	350	400	400
Amp.(A)	V-down	80~120	100~150	150~200	210~250

Approvals

ABS	BV	LR
2	2	2m

* Others : KS, JIS, CE