

# S-6013.LF

Type : Rutile

## Conformances

AWS A5.1/ ASME SFA5.1 E6013

JIS Z3211 E4313

EN ISO 2560-A E38 0 R 1 2

KR 2

ABS 2

LR 2

BV 2

DNV 2

GL 2

NK KMW2

NAKS

## Applications

- General fabrication

## Features

- Suitable for butt and fillet welding of thin plates
- Good restriking
- Good bead appearance
- Easy to remove slag
- Smooth arc and low fume
- AC welding with low ocv

## Welding Position



1G 2F 3G 4G  
(PA) (PB) (PF) (PE)

## Current

AC or DC ±

## Redrying Conditions

70~100°C (158~212°F) X 0.5~1hr

## Diameter / Packaging

Diameter	Length	Standard		Vacuum				P.V.C	
		packet	carton	packet	carton	packet	carton	packet	carton
mm (in)	mm (in)	5kg(11lbs)	20kg(44lbs)	1.5kg(3.3lbs)	15kg(3.3lbs)	5kg(11lbs)	20kg(44lbs)	5kg(11lbs)	20kg(44lbs)
2.6 (3/32)	350 (14)		✓						
3.2 (1/8)	350 (14)		✓						
4.0 (5/32)	400 (16)		✓						
	450 (18)								
5.0 (3/16)	400 (16)		✓						
	450 (18)								
6.0 (15/64)	450 (18)		✓						

### Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.05	0.23	0.35	0.022	0.017

### Typical Mechanical Properties of All-Weld Metal

Condition	YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft-lbs)
AW	439 (63,700)	488 (70,900)	26.8	0 (32)	67 (50)

### Typical Operating Procedures

Diameter mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)	6.0 (15/64)
Length mm (in)	350 (14)	350 (14)	400 (16) 450 (18)	400 (16) 450 (18)	450 (18)
F & HF	50~95A	80~130A	120~180A	160~230A	220~300A
V-up, OH	45~90A	60~120A	100~160A	120~220A	-