

SM-13

AWS A5.1 E6013
JIS Z3211 E4313
EN ISO 2560-A E 38 3 R 1 2

COVERED ELECTRODES FOR MILD STEEL

DESCRIPTION :

SM-13 is a high titania electrode designed for all-positional welding including vertical down position with good weldability and nice bead appearance.

APPLICATIONS :

It is used for welding of steel structures of shipbuilding, railway vehicles and cars. It is also suitable for thin pipe and other ornamental works.

NOTE ON USAGE :

1. Dry the electrodes at 80 ~ 100°C for 30 ~ 60 minutes prior to use.
2. Clean up the the base metal to be free from contamination.

WELDING POSITION:

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

Weld Metal Analysis :

Carbon (C)	0.058
Manganese (Mn)	0.29
Silicon (Si)	0.2
Phosphorus (P)	0.021
Sulphur (S)	0.009

TYPICAL MECHANICAL PROPERTIES OF WELD METAL:

YP N/mm ²	422
TS N/mm ²	468
EL%	26

TYPICAL IMPACT VALUES :

IV 0°C J	65
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APPROVALS :

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SIZES AND RECOMMENDED CURRENT RANGE (AC or DC <±>)

Diameter mm	Length mm	Amp	
		F	V & OH
2.6	350	60 ~ 90	50 ~ 80
3.2	350	100 ~ 120	80 ~ 100
4.0	400	110 ~ 160	110 ~ 150
5.0	400	160 ~ 220	140 ~ 200