

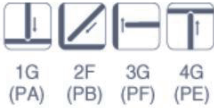
## E6013 LF (Low Fume)

AWS A5.1 E6013  
ISO2560-A-E38 0 R1 12  
GB/T 5117 E4313

### Description:

Improved formulation featured with 30% decrease of welding fume and better anti-moisture performance.

### Welding Position:



**Diameters:** 2.5mm, 3.2mm, 4.0mm, 5.0mm.

### Typical Mechanical Properties:

Tensile strength(MPa):	491
Yield strength(MPa):	398
Elongation (%):	26
Impact values( $\geq 47$ )/(-20℃):	81

### Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	V
0.08	0.43	0.026	0.021	0.21	0.04	0.011	0.007	0.009

### Welding Current:(AC/DC+)

Diameter(mm)		2.5	3.2	4.0	5.0
Current/A	F/H	60-90	80-130	150-190	180-250
Current/A	V/OH	50-80	80-110	130-170	--

### Note:

No need to bake before using, please bake 30-60 minutes in 150℃ if the electrodes is humid,