

E6013 VD (Vertical Down)

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

Description:

Improved formulation featured with very good vertical down position welding performance because of the higher grade rutile used, Very easy to strike and restrike even on low no-load voltage welding machines.

Welding Position:



Diameters:

2.5mm, 3.2mm, 4.0mm, 5.0mm.

Typical Mechanical Properties:

Tensile strength(MPa):	495
Yield strength(MPa):	400
Elongation (%):	26
Impact values(≥ 47)/(-20°C):	80

Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	V
0.083	0.42	0.024	0.023	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, but please bake 30-60 minutes in 150°C if the electrodes is humid.