



# E6013 LF

GP RUTILE TYPE STEEL WELDING ROD  
LOW FUMING

| SIZE  | AMPS     |
|-------|----------|
| 2.5mm | 60-90A   |
| 3.2mm | 80-130A  |
| 4.0mm | 150-190A |
| 5.0mm | 180-250A |

## CLASSIFICATION

AWS A5.1 E6013  
EN ISO2560-A E38 0 R 1 2

## PACKING SPECIFICATION

\*1kg PE bag  
\*5kg Cardboard Box

## CURRENT TYPE

AC/DC+

## CHEMICAL COMPOSTIONS (Wt%), ALL WELD METAL, TYPICAL

| C    | Mn   | Si   | S     | P     |
|------|------|------|-------|-------|
| 0.05 | 0.36 | 0.23 | 0.012 | 0.015 |

## MECHANICAL PROPERTIES, ALL WELD METAL, TYPICAL

| Condition | Yield Strength (Mpa) | Tensile Strength (Mpa) | Elongation (%) | Charpy V notch (J) |
|-----------|----------------------|------------------------|----------------|--------------------|
| AW        | 435                  | 485                    | 28             | -30 C 72           |

Note: ① Re-dry it at 150°C for 30-60 minutes if it is damp.

## TYPICAL APPLICATIONS

1. Sheet metal
2. General Fabrication

## CHARACTERISTICS

1. 30% decrease in welding fume
2. All positional welding capability
3. Easy slag removal and minimum spatter
4. User friendly and uniform bead formation
5. 45% high content of #85 rutile used

## AVAILABLE SIZES (DIA./LENGTH)

2.5mm\*350mm  
3.2mm\*350mm  
4.0mm\*400mm  
5.0mm\*400mm

## EQUIVALENT TO

Lincoln Fleetweld 37  
Esab Sureweld 6013  
Hyundai S-6013.LF  
Kiswel KR-3000  
Indura 6013