



E6013 VD

VERTICAL DOWN

GP CARBON STEEL WELDING ROD

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 1

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	0C 65

TYPICAL APPLICATIONS

- 1, Sheet metal
- 2, General Fabrication

CHARACTERISTICS

1. All positional including vertical down welding capability
2. Self-releasing slag and minimum spatter
3. User friendly and uniform bead formation
4. 60% high content of 92% rutile used
5. Improved on basis of formulas from Australia & Switzerland

AVAILABLE SIZES (DIA./LENGTH)

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

EQUIVALENT TO

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