

# E6013 VD

VERTICAL DOWN

GP CARBON STEEL WELDING ROD



**TecMig**  
The pro's choice



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<br>(Mpa) | Tensile Strength<br>(Mpa) | Elongation<br>(%) | Charpy V<br>notch (J) |
|-----------|-------------------------|---------------------------|-------------------|-----------------------|
| AW        | 435                     | 485                       | 28                | 0℃ 65                 |

## TYPICAL APPLICATIONS

- 1, Sheet metal
- 2, General Fabrication

## CHARACTERISTICS

1. Top quality #92 rutile ensures all postional including vertical down welding capability
2. Japan Technology
3. Easy to operate and uniform bead appearance
4. Stronger arc force increases welding efficiency

## 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℃ for 30-60 minutes if it is damp.