



FEAT CRAFT Mild Steel 6013 Welding Electrode



**EXCELLENT WELDING PERFORMANCE AND
SATISFACTORY IN VARIOUS WELDING POSITION**

(Manufactured under quality system certified to ISO9001:2008)

SPECIFICATION

AWS : A5.1 / E6013 (WITH HIGH TITANIA POTTASSIUM TYPE COATING)

MECHANICAL OF PROPERTIES OF DEPOSITED METAL

	Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)
AWS E6013 Requirement Typical Value	Min 306	Min 430 - 560	Min 22
	395	490	28

CHEMICAL COMPOSITION – AS WELDED

	C	Mn	Si	S	P
AWS 6013 Requirement Typical Value (%)	Min 2.00	Min 1.2	Min 1.00	Min 0.035	Min 0.040
	0.070	0.41	0.26	0.021	0.023

CHEMICAL COMPOSITION – AS WELDED

Diameter x Length	Weight (kg)		Packet per Carton	Product Number
	Packet	Carton		
2.5mm x 300mm	5	20	4	DN23-325
3.2mm x 350mm	5	20	4	DN23-332
4.0mm x 400mm	5	20	4	DN23-340
5.0mm x 400mm	5	20	4	DN23-350

RECOMMENDED WELDING CURRENT (DC / AC)

Diameter x Length		2.5 X 300	3.2 X 350	4.0 X 400	5.0 X 400
CURRENT (A)	F , H	60-90	80-130	150-190	180-250
	V, OH	50-80	80-110	130-170	-

Welding Position

ALL POSITION



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