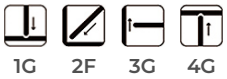
# S-6013.LF

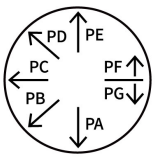


## Classification

AWS A5.1/ASME SFA-5.1 E6013
JIS Z 3211 E4313
EN ISO 2560-A E38 0 R 1 2
KS D7004 E4313

## Welding Positions




## Features

- Suitable for butt and fillet welding of thin plates
- Good restriking
- Good bead appearance
- Easy to remove slag
- Smooth arc and low fume
- AC welding with low ocv

## Polarity

AC or DC +

## Application Areas

- General fabrication

## Redrying Conditions

70~100°C (158~212°F) X 0.5~1hr

## Approvals

| ABS | BV | DNV | KR | LR | NK | CE |
|---|---|---|---|---|---|---|
| ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ |

## Typical Chemical Composition of All-Weld Metal (wt%)

| C | Si | Mn | P | S |
|---|---|---|---|---|
| 0.06 | 0.26 | 0.34 | 0.020 | 0.011 |

## Typical Mechanical Properties of All-Weld Metal

| Yield Strength MPa(ksi) | Tensile Strength MPa(ksi) | Elongation (%) | Temperature °C (°F) | Impact Toughness J (ft·lbs) |
|---|---|---|---|---|
| 418(61) | 497(72) | 26 | 0(32) | 57(42) |

## Diameter / Welding Parameters / Packaging

| Diameter mm(in) | Length mm(in) | F & HF | V-up, OH | Packaging |
|---|---|---|---|---|
| 2.6(3/32) | 350(14) | 55-95 | 45-90 | Standard/Vacuum - Packet 5kg (11lbs), Carton 20kg (44lbs) |
| 3.2(1/8) | 350(14) | 80-130 | 60-120 | |
| 4.0(5/32) | 400(16)/450(18) | 120-180 | 100-160 | |
| 5.0(3/16) | 400(16)/450(18) | 160-260 | 120-200 | |
| 6.0(15/64) | 450(18) | 220-300 | - | |