

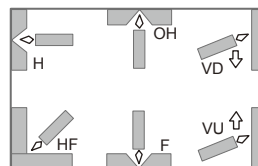
## High titania type covered electrode

**Classification:** ASME / AWS A 5.1 E6013  
EN ISO 2560-A-E 35 0 R  
JIS Z3211 E4313

**Features:** •Suitable for butt and fillet welding of thin plates  
•Excellent usability in all positions including vertical downward

**Redrying Conditions:** 70~100°Cx0.5~1h

## Welding Positions:



## Chemical composition of all-weld metal (%) as per AWS

|          | C         | Si        | Mn        | P      | S      |
|----------|-----------|-----------|-----------|--------|--------|
| Example  | 0.08      | 0.30      | 0.37      | 0.012  | 0.010  |
| Guaranty | 0.05~0.12 | 0.15~0.45 | 0.25~0.65 | ≤0.030 | ≤0.025 |

## Mechanical properties of all-weld metal as per AWS

|          | YP<br>(MPa) | TS<br>(MPa) | EI<br>(%) |
|----------|-------------|-------------|-----------|
| Example  | 450         | 510         | 25        |
| Guaranty | ≥330        | ≥410        | ≥17       |

## Recommended welding parameters

|              | 2.0mm  | 2.6mm  | 3.2mm   | 4.0mm    | 5.0mm    |
|--------------|--------|--------|---------|----------|----------|
| F, HF, H, VD | 30~65A | 45~95A | 60~125A | 105~170A | 150~220A |
| VU, OH       | 30~65A | 45~95A | 60~125A | 100~150A | 125~190A |

## Polarity

|          |                  |
|----------|------------------|
| Example  | AC               |
| Guaranty | AC, DC-EP, DC-EN |

## Approvals

| ABS | LR | NK   |
|-----|----|------|
| 2   | 2m | KMW2 |

## Packages

| Dia.<br>(mm) | Length<br>(mm) | Weight per<br>pack (kg) | Weight per<br>carton (kg) | Weight per<br>piece (g) |
|--------------|----------------|-------------------------|---------------------------|-------------------------|
| 2.0          | 300            | 2                       | 20                        | 10                      |
| 2.6          | 350            | 5                       | 20                        | 19                      |
| 3.2          | 350            | 5                       | 20                        | 29                      |
| 4.0          | 400            | 5                       | 20                        | 53                      |
| 5.0          | 400            | 5                       | 20                        | 81                      |