

KT-413

Classification

AWS	A 5.1/A5.1M	E6013/E4313
JIS	Z3211	E4313
EN	2560-A	E35 0 R 1 2
GB	T5117	E4313

Type of coating : Rutile type

Applications and Features

- (1) Designed for thin plate welding, such as vehicles, light steel structures and decoration bead .
- (2) Stable arc, easy re-start, easy control of weld puddle, low spatters, good slag removal and bead appearance and appropriate penetration.

Welding position



Welding Instruction

- (1) Please refer to Appendix A

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S
0.07	0.36	0.45	0.023	0.007

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
491	427	25	0	71

Size and Suggested Operating Range (AC or DC±)

Diameter (mm)		2.6	3.2	4.0	5.0
Current (A)	F/H-fillet	60~90	90~120	110~160	160~220
	V/OH	50~80	70~100	100~150	-