

CLASSIFICATION

EN ISO 2560-A : E 42 0 RR 12
AWS A5.1 : E6013

GENERAL DESCRIPTION

L-13 is a heavily coated rutile electrode. Weld metal has a high resistance to cracking. The slag is easy to remove, and it gives high quality, excellent smooth weld beads. It is easy to strike and re-strike and thus an ideal and easy to use electrode. Basic component quantity is less than L-13.

APPROVALS

GOST, SEPRO, TSE

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Si	Mn
0.08	0.40	0.60

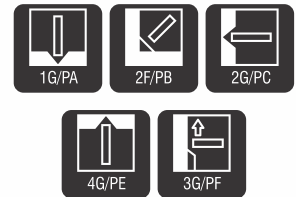
MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Yield Strength	: 450 N/mm ²
Tensile Strength	: 550 N/mm ²
Elongation (L=5d)	: 25 %
Impact (ISO-V)	: 50 J (0°C)

WELDING PARAMETERS / PACKING AND DIAMETER INFORMATIONS / WELDING POSITIONS

Current Type and Polarity : AC min 50 V ; DC (-)

Diameter [mm]	Length [mm]	Current [A]	Electrode Weight [g/100 pcs]	Box Weight [kg] Quantity [pcs/box]	Export Box Box Weight [kg]
2.00	300	45 - 70	1100	1.9 / 175	2
2.50	350	50 - 110	2140	2.1 / 100	5
3.25	350	90 - 140	3450	3.4 / 100	5
4.00	450	140 - 190	6670	6.7 / 100	6



APPLICATIONS AND MATERIALS TO BE WELDED

L-13 is a general purpose electrode especially used for the welding of medium carbon steels and particularly suitable for butt welding of thin plates and sheet steels. It is also useful for welding mild structural steels and pressure and boiler vessel steels having a tensile strength up to 500 N/mm². Ship's plate of A- quality, automotive bodies and welding of thin plates are among its application areas.

	DIN	EN
General Structural Steels	St 33, St 34, St 37, St 44, St 44-2, St 44-3, St 52, St 52-3 St 37-4, St 44-4, St 52-4	S185, S235, S275, S355 P235TR2 - P355T2
Fine Grained Steels	StE 255 - StE 420 WStE 255	S255N - S420N P255NH
Pipe Materials	StE 210-7 - StE 360-7 StE 290-7 TM - StE 360-7 TM X42, X46, X52, X60 (API 5LX)	L210 - L360NB L290MB - L360MB
Boiler and Pressure Vessel Steels	17 Mn 4, 19 Mn 6 HI, HII, HIII	P295GH, P355GH P235GH, P265GH, P285NH
Elevated Temperature Steels	St 35-8, St 45-8	P235G1TH - P255G1TH
Ship Plates	A, B, D AH32 - EH36	- -
Cast Steels	GS-38, GS-45, GS-52	GE200, GE240, GE260

Liability : All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance.
Fumes : Consult information on Welding Safety Sheet, available upon request.