

KT-413V

Classification

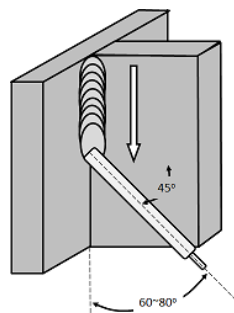
AWS	A 5.1/A5.1M	E6013/E4313
JIS	Z3211	E4313
EN	2560-A	E35 0 R 1 1
GB	T5117	E4313

Type of coating : Rutile type

Applications and Features

- (1) Ideal for vertical down welding..
- (2) Wide operating range, excellent slag removal and smooth bead appearance.
- (3) Suitable for thin plates and light structures.

Welding position



Welding Instruction

- (1) Please refer to Appendix A

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S
0.07	0.19	0.35	0.015	0.008

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
468	425	26	0	65

Size and Suggested Operating Range (AC or DC±)

Diameter (mm)		2.6	3.2	4.0	5.0
Current (A)	F/H-fillet	70~100	1100~130	120~170	170~230
	V-down/OH	70~100	110~130	120~170	-