

KT-413

Classification

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

Coating Type: High Titania

Applications and Features

- (1) KT-413 is a high titania type electrode for mild steel.
- (2) Stable arc, shallow penetration, and excellent burn-through resistance on thin sheet metal.
- (3) Easy strike and re-strike, low spatter, easy slag removal, and good bead appearance.
- (4) Ideal for welding automotive, thin sheet metal, and light steel structure.

Welding Position



Welding Instruction

Please see Appendix A

Typical Weld Metal Composition (wt%)

C	Si	Mn	P	S
0.07	0.36	0.45	0.023	0.007

Typical Weld Metal Mechanical Properties

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

Available Sizes and Welding Parameters (AC/DC±)

Diameter (mm)		2.6	3.2	4.0	5.0	6.0
Current (A)	F/HF	70~110	110~150	130~190	170~240	230~300
	V-up/OH	40~70	60~120	110~160	-	-