LOW ALLOY ELECTRODE, HEAT RESISTANT UP TO 550°C

EURO 8013 G

CLASSIFICATION:

AWS/ASTM: E 8013-G

APPLICATIONS:

Welding of low alloy steels with Mo as alloying elements and heat resistance upto 550°C. Also suitable for light repairs.

CHARACTERISTICS:

The weld metal deposited is heat resistant upto 550°C, heat treatable and suitable for case-hardening. The weld beads are of regular shape and free of porosis.

CURRENT MODE:

Direct current (+ polarity and – polarity), alternating current.

CHEMICAL ANALYSIS OF WELD DEPOSIT, TYPICAL VALUES IN %:

Element	C	Mn	Si	Fe	Mo
%	0.06	0.7	0.3	Remainder	0.40

MECHANICAL PROPERTIES:

Y.S. N/sq mm.	UTS N/sq mm	% Elongation	Impact value (DVM)
400	560	25	103-130 J

RECOMMENDED CURRENT RANGES

SIZE mm	2.50 X 300	3.20 X 350	4.00 X 350	5.00 X 350
CURRENT- Amps	70-90	100-130	130-150	160-190