

SM-6013

SMAW ELECTRODE - MILD STEEL

CLASSIFICATIONS :

AWS A5.1 E6013

ASME SFA A5.1 E6013

JIS Z 3211 E4313

BS EN ISO 2560-A E 38 3 R 1 2

DESCRIPTION

SM-6013 is a high titanium electrode designed for all position welding including vertical down position with good weldability and nice bead appearance

FEATURES

Smoother arc transfer, Easier slag removal, Less Spatter.

Excellent usability in all positions welding including vertical down.

Suitable for butt and fillet welding of thin plates/sheets.

Smooth and bright weld seams, Smoother with a finer ripple bead surface.

Stable arc on AC and DC.

APPLICATIONS

Welding light sheet metals and light-gauge formed steel in light-duty steel structures.

Surfacing thick-section welds to improve rough surfaces (the surface dressing technique).

Maintenance or repair welding.

CHEMICAL COMPOSITION

	%C	%Mn	%Si	%P	%S
Requirements	0.20 max	1.20 max	1.00 max	Not Specified	Not Specified
Typical Results	0.058	0.29	0.2	0.021	0.009
	%Ni	%Cr	%Mo	%V	
Requirements	0.30 max	0.20 max	0.30 max	0.08 max	
Typical Results					

MECHANICAL PROPERTIES

	Tensile Strength, Mpa	Yield Strength, Mpa	Elongation, %
Requirements	430 min	330 min	17 min
Typical Results	468	422	26

OPERATING PROCEDURES

Polarity	Current (Amps)				
	Ø2.0 mm	Ø2.6 mm	Ø3.2 mm	Ø4.0 mm	Ø5.0 mm
AC	50 - 80	75 - 115	110 - 140	160 - 200	205 - 260
DC ±	45 - 75	70 - 105	100 - 135	145 - 180	185 - 235

WELDING POSITION



NOTE

Electrodes that have become damp should be re-dried at 300-350 °C for 1 hour before welding, do not dry twice to avoid detachment of covering.

SPECIAL METAL KOREA CO., LTD.

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