



Classifications:
 AWS- A5.11 E6013
 EN-499 E 35 0 R 12
 JIS Z3211 E4313

KE6013

Electrode for Low Carbon Steel

Type of Flux Coating : Rutile

Characteristics and Applications:

KE6013 is rutile type coated electrode for high efficiency welding. It performs excellence with good slag removal, shallow penetration, less spatter, and smooth bead appearance. It can be done in all position. It is suitable for welding application of vehicles, steel sheets and other light structures.

Welding Position:

Typical Chemical Composition of Weld Metal:

Alloy wt%	C	Mn	Si	P	S
AWS	0.20	1.20	1.00	0.023	0.013
Tested	0.068	0.42	0.27	0.023	0.013

Typical Mechanical Properties of Weld Metal:

Mechanical properties	Y.S.(MPa)	Y.S.(MPa)	El(%)	CVN J/
AWS	330	430	17	56,60,65 AVE.60
Tested	430	500	24	56,60,65 AVE.60

Notes on Usage:

1. Pay attention not to exceed proper current range and available with AC and DC welding.
2. Re-bake the electrode at 80 - 100°C for 30 - 60 minutes before use.
3. Clean up the contaminations on the base metal to reduce welding defect.
4. Apply proper current to get excellent X-Ray soundness and mechanical properties.

Sizes Available and Recommended Parameters:

Diameter(mm)	2.6 x 350	3.2 x 350	4.0 x 450	5.0 x 450
Current F	60 - 90	100 - 120	100 - 120	160 - 200
(Amp) OH,V	50 - 80	80 - 100	80 - 100	

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