

CR-13

For welding of general light structural steels.

AWS A5.1 E6013
KS D 7004 E4313
JIS Z3211 E4313

Applications

Welding of vehicles, machines and light structural steels. Surface dressing of heavy steel structure.

Characteristics

CR-13 is a high titania type electrode, whose usability is excellent in all position welding. CR-13 is especially suitable for welding of light structural steels because arc stability, slag removal and bead appearance are good and its penetration is shallow.

Notes on usage

- (1) Pay attention not to exceed the range of proper currents. Welding with excessive current not only lowers X-ray soundness, but also causes increase of spatter, undercut and insufficient slag covering.
- (2) Dry the electrodes at 70~100°C for 30~60 minutes before use. Excessive moisture absorption lowers usability and may result in some porosities.

Typical chemical composition of weld metal (%)

C	Mn	Si	P	S
0.08	0.38	0.28	0.017	0.011

Typical mechanical properties of weld metal

YP N/mm ² (kgf/mm ²)	TS N/mm ² (kgf/mm ²)	EL %
430(44)	480(49)	29

Size & recommended current range (AC or DC ±)

Dia. (mm)	2.0	2.6	3.2	4.0	5.0	6.0	
	L (mm)	300	350	350	400	400	450
Amp.	F	35-65	45-100	60-130	105-170	150-220	200-280
	V&OH	30-65	45-90	60-110	100-150	125-190	-

• Approval : ABS, DNV, KR, LR, NK

• Tip Color : Yellow