

COVERED ELECTRODES FOR MILD STEEL

DESCRIPTION & APPLICATIONS :

- SM-13 is a high titania electrode with stable arc, good penetration. It suitable for thin thickness base metal.
- Good on arc and re-start arc welding. Nice bead appearance, less spatter and slag removable easily.
- It is used for vehicle sheet, thin steel sheet and other ornamental works.

NOTE ON USAGE :

- Dry the electrodes at 80~100°C for 30~60 minutes prior to use.
- Proper welding current is recommended to get good X-ray soundness.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S
0.058	0.29	0.2	0.021	0.009

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YP N/mm ² (Kgf/mm ²)	TS N/mm ² (Kgf/mm ²)	EL %	IV 0°C J(Kgf-m)
422(43.1)	468(47.8)	26	65(6.6)

SIZE AND RECOMMENDED CURRENT RANGE : AC or DC(±)

Diameter (mm)		3.2	4.0	5.0
Length (mm)		350	450	450
Amp.	F	90-130	130-160	160-220
	V & OH	80-100	110-150	140-200