



M-90 E6013

FEATURES

- *SUITABLE FOR BUTT AND FILLET WELDING OF THIN PLATES
- *GOOD RESTRIKING
- *GOOD BEAD APPEARANCE
- *EASY TO REMOVE SLAG
- *SMOOTH ARC AND LOW FUME
- *AC WELDING WITH LOW OCV

APPLICATION

Welding of general low carbon steel.

*Coating Type: Rutile

*Welding Current: DC-, AC

*Welding Positions: all, besides vertical down

CLASSIFICATION

*AWS/A5.1/ASME SFA5.1 E6013

CHEMICAL COMPOSITIONS

C	Si	Mn	P	S	CR	Ni	MO
0.05	0.23	0.35	0.022	0.017			

MECHANICAL PROPERTIES

Y.S	T.S	EL	Temp.	CVN-Impact Value
N/mm ² (lbs/in ²)	N/mm ² (lbs/in ²)	(%)	oC (oF)	J (ft lbs)
439 (63,700)	488 (70,900)	26.8	0 (32)	67 (50)

WELDING PARAMETERS






DIAMETER (mm)	1.6	2	2.5	3.2	4	5
LENGTH (mm)	300	300	300	350	350	400

CURRENT (amps)	50-70	55-70	50-90	80-120	100-160	120-220
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CURRENT

*AC or DC +

WELDING POSITIONS

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= +	~	(U _o : 50 V)							
ASME:	1G	2F	2G	3G	4G	Current			
ISO 6947	PA	PB	PC	PF	PE				