

7013

CONTACT WELDING ROD WITH A SPECIAL COVERING FOR LOW CARBON AND LOW ALLOY STEEL.

CLASSIFICATION A.W.S: N/A

IDENTIFICATION: BLUE COATING

APPLICATIONS: E-7013 has a high efficiency rate of filler metal since no material is lost due to splatter. It is a very economical welding rod from this point of view.

This welding rod has very little penetration and its arc is quiet. Not only the filler metal but also the slag cool down quickly. This allows to control the filler metal while welding and to weld very wide joints. This electrode weld metal has great tension resistance which makes it suitable for delicate jobs. Since the filler metal cools down so quickly, the slag peels off. The filler metal can be peened while hot. This is a high speed welding rod with a high filler metal rate and it is specially suitable for production applications.

It can be used to weld joints in all positions during maintenance and production operations. It is recommended for those jobs where it is indispensable that weld seams look nice.

CHARACTERISTICS AND PROCEDURE: 7013 belongs to the category of ruthenic welding rods with a thick covering. It has been specially formulated to produce excellent looking weld beads with a high efficiency filler metal rate and very little splatter. Its arc is quiet and the slag peels off. Its contact arc is short.

TENSILE RESISTANCE:	5,100 - 5,700 KG./CM2 (72000 A 81000 PSI)
ELASTIC LIMIT:	4,200 - 4,600 KG./CM2 (59,725 A 65,410 PSI)
ELONGATION IN 5 cm:	25%
BRINELL HARDNESS:	160 BHN
POSITIONS:	AL
CURRENT:	AC or DC REVERSE POLARITY

FILLER METAL CHEMICAL ANALYSIS %					SIZES	AMPERAGE
C	Mn	P	S	Si		
0.10	0.60	0.03	0.03	0.30	2.25 mm - 3/32"	65-90
					3.25 mm - 1/8"	100-140
					4.0 mm - 5/32"	140-180
					5.0 mm - 3/16"	200-250