



Characteristics

Preferably used in mild steel fabrication, sheet metal and ornamental iron works on poor fitup joints. Due to its iron powder addition in covering, particularly suited for the welding of horizontal fillets grooves with higher speed. Suitable for all position welding except vertical-down. High current carrying capacity, low spatter. Quite, stable arc characteristics with fine and fast droplet metal transfer. Very easy arc striking and re-striking. Very smooth welds blending into base metal without undercuts. Slag is completely self-releasing. Possible to use equally well both with AC and DC.

Base Material



Typical applications

used in mild steel fabrication, sheet metal and ornamental iron works on poor fitup joints. Due to its iron powder addition in covering, particularly suited for the welding of horizontal fillets



Typical Analysis in %

Typical Chemical Analysis	%C	%Mn	%Si	%S	%P
	0.06	0.55	0.40		
	%Cr	%Ni	%Mo	%Cu	%Ti

	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elongation A5 %	Impact Energy J
Typical Results (all weld metal)				
As Welded	500 mpa	560 mpa	28	0C 50 J

Mechanical Properties as required per AWS A5.28 ER100S-1

Shipping Information

Article Number	Product	Dimension	Packaging
1113010M15	ESR 13 (E6013)	2.5x350mm(3/32X14")	3X5 KG (3X11 lb) Cardboard
1113016M15	ESR 13 (E6013)	3.25X350mm(1/8X14")	3X5 KG (3X11 lb) Cardboard
1113020M15	ESR 13 (E6013)	4.0X350mm(5/32X14")	3X5 KG (3X11 lb) Cardboard
1113032M15	ESR 13 (E6013)	5.0X350mm(3/16X14")	3X5kg (3X11 lb) Cardboard

