

R-13

HIGH TITANIA TYPE

JIS Z 3211 D4313
AWS A5.1 E6013
EN499 E 35 0 R 12

Characteristics and Applications:

R-13 is designed for high efficiency welding with thin flux coating. It performs excellence with good slag release, shallow penetration, less spatters, and smooth bead appearance. It is suitable for welding application of vehicles, steel sheets and other light structures.

Notes on Usage:

1. Proper current range and available with AC or DC welding.
2. Dry the electrode at 80-100°C for 30~60 minutes.
3. Clean up the contaminations on the base metal to reduce welding defect.
4. Apply proper currents to prevent X-Ray and mechanical properties from being worse.

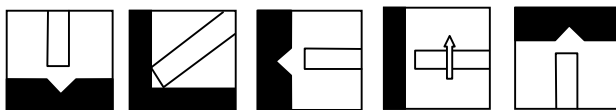
Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S
0.08	0.3	0.20	0.02	0.01

Typical mechanical properties of weld metal

YS (MPa)	TS (MPa)	EL %	CVN 0°C J
430	480	25	50

Welding position



Sizes and recommended current range (AC or DC $\langle \pm \rangle$)

Diameter (mm)	1.6	2.0	2.6	3.2	4.0	5.0	
Length (mm)	300	300	350	350	450	450	
Amps	F	20-50	30-60	60-90	90-130	110-180	160-220
	V&OH	20-40	30-55	50-80	80-100	110-150	140-200

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Tien Tai Electrode Co., Ltd. expressly disclaims any liability incurred from any reliance thereon. Typical data is obtained when welded and tested in accordance with AWS specification. Other tests and procedures may produce different results. No data is to be construed as recommendation for any welding condition or technique not controlled by Tien Tai Electrode Co., Ltd.