

CR-13V

For welding of steel sheets and light structures.

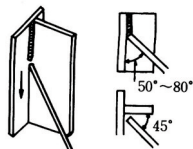
AWS A5.1 E6013
KS D 7004 E4313
JIS Z3211 E4313

Applications

Welding of steel sheet structures in ships, railway vehicles and cars.

Characteristics

CR-13V is a high titania type electrode which provides good usability in all positions, including vertical downward welding. The arc is stable with little spatter and the lustrous bead can be obtained. CR-13V is suitable for welding steel sheets and light structures because of shallow penetration.



Notes on usage

- (1) In the case of vertical downward welding, manipulate the electrode keeping its tip in contact with mother plate as shown in the sketch.
- (2) Pay attention not to exceed the range of proper currents. Welding with excessive current not only lowers X-ray soundness, but also causes increase of spatter, undercut and insufficient slag covering.
- (3) Dry the electrodes at 70~100°C for 30~60 minutes before use. Excessive moisture absorption lowers usability and may result in some porosities.

Typical chemical composition of weld metal (%)

C	Mn	Si	P	S
0.08	0.38	0.29	0.016	0.012

Typical mechanical properties of weld metal

YP N/mm ² (kgf/mm ²)	TS N/mm ² (kgf/mm ²)	EL %
440(45)	500(51)	27

Size & recommended current range (AC or DC±)

Dia. (mm)	2.0	2.6	3.2	4.0	5.0	
	L (mm)	300	350	350	400	400
Amp.	F	30-65	45-95	80-130	120-165	180-230
	V&OH	30-60	45-90	80-120	120-155	180-220

• Tip Color : Black