

CR-13

For welding of general light structural steels.

AWS A5.1 E6013
KS D7004 E4313
JIS Z3211 E4313

Applications

Welding of vehicles, machines and light structural steels. Surface dressing of heavy steel structure.

Characteristics

CR-13 is a high titania type electrode, whose usability is excellent in all position welding. CR-13 is especially suitable for welding of light structural steels because arc stability, slag removal and bead appearance are good and its penetration is shallow.

Notes on usage

- (1) 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.
- (2) 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	0.28	0.017	0.011

Typical mechanical properties of weld metal

YP N/mm ² (kgf/mm ²)	TS N/mm ² (kgf/mm ²)	EL %
430(44)	480(49)	29

Size & recommended current range (AC or DC ±)

Dia. (mm)	2.0	2.6	3.2	4.0	5.0	6.0	
L (mm)	300	350	350	400	400	450	
Amp.	F	35-65	45-100	60-130	105-170	150-220	200-280
	V&OH	30-65	45-90	60-110	100-150	125-190	-

• Approval : ABS, DNV, KR, LR, NK

• Tip Color : Yellow