

CR-13V

For welding of steel sheets and light structures.

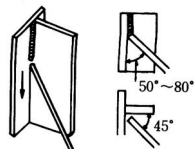
AWS A5.1 E6013
KS D7004 E4313
JIS Z3211 E4313

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