PRODUCT DATA SHEET

WCD 6102

GENERAL PURPOSE ELECTRODES - MILD STEEL

Austarc 13S



SUMMARY

- General Purpose Rutile Type Electrode
- Versatile/All Positional (Especially Vertical Up) Capabilities
- Ideal for Down Hand Fillet Welding of Mild Steel
- Smooth Performance on Low OCV AC Welding Machines

IDENTIFICATION

Coating - Blue/White Stripe **Tip** - Plain **Imprint** - WIA 4313A

CLASSIFICATION

- AS/NZS 4855-B - E43 13A
- AWS A5.1: E6013

DESCRIPTION AND APPLICATION

Austarc 13S is the popular “blue and white striped” general purpose electrode for smooth mitre fillet welding applications. 13S has a soft and stable arc and produces flat, uniform fillet welds with ease and a self peeling slag action.

Austarc 13S is formulated primarily for fillet welding in all down hand positions. It is ideal for the general purpose and structural welding of sheet and plate steels (galvanised or otherwise) and tubular components, including trailers, duct work, hoppers and storage tanks, etc.

OPERATIONAL DATA

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	WELDING CURRENT RANGE *(A)	ARC VOLTAGE RANGE **(V)
2.5	300	60 - 85	20
3.2	380	100 - 130	21
4.0	380	140 - 180	22

*Recommended for DC +/- or AC (minimum 45 OCV) operation.
**Voltage is determined by arc current and electrode arc length.
Arc voltage shown is typical and is only to be used as a guide.

SHIPPING APPROVAL

LR 2m **ABS** 2 **DNV** 2

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si	P	S	Fe
0.07	0.48	0.41	0.016	0.005	Bal

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Yield Stress	450 MPa
Tensile Strength	520 MPa
Elongation	26%
CVN Impact Values	60J @ 0°C

In as welded condition.

PACKAGING DATA

ELECTRODE SIZE (MM)	PACKAGING (KG)		APPROX. NO. OF RODS PER KG	PART NO.
	PACKET	CARTON		
2.5	2.5	12.5	64	13S25
3.2	5.0	15	31	13S32
4.0	5.0	15	20	13S40

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