

## Applications

S-6013.LF can be used for welding of machinery, vehicles and light structural steels, and surface dressing of heavy steel structures.

## Characteristics on Usage

S-6013.LF is a low fume, high titania type electrode. Fume generation is about 20% less than conventional high titania type electrodes and whose usability is excellent in all position welding. S-6013.LF is suitable for welding of light structural steels because of its stable arc, shallow penetration and smooth welding bead.

## Notes on Usage

- ① Dry the electrodes at 70~100°C(158~212°F) for 30~60 minutes before use.
- ② Pay attention not to exceed the range of proper currents.

## Welding Position



1G (PA)    2F (PB)    3G (PF)    4G (PE)

## Current

AC or DC ±

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.05	0.23	0.35	0.022	0.017

## Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
439 (63,700)	488 (70,900)	26.8	0 (32)	67 (50)

## Approval

KR, ABS, LR, BV, DNV, GL, NK, NAKS

## I Packing

Packet 5 kg (11 lbs)  
Carton 5 kg (11 lbs) × 4 : 20kg(44 lbs)

## Sizes Available and Recommended Currents (Amp.)

Size mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)	6.0 (15/64)
Length mm(in)	350 (14)	350 (14)	400 (16) 450 (18)	400 (16) 450 (18)	450(18)
F	50~95	80~130	120~180	160~230	220~300
V-up, OH	45~90	60~120	100~160	120~200	-