

**SMAW**

For Mild Steel

**POWERWELD G-13**

CLASSIFICATION : AWS A5.1 E6013

JIS Z3321 E4313

WELDING POSITIONS :

**Approval**

Lloyds Register Of Shipping	Grade 2
American Bureau Of Shipping	Grade 2

**DESCRIPTION AND APPLICATIONS**

POWERWELD G-13 is a smooth running, rutile type electrode for all position welding. Superb arc starting, low spatter levels, and self-releasing slag for greater welder appeal. Suitable for welding mild steel, galvanized pipes and plates, and structures that require Galvanized after welding.

**TYPICAL ALL WELD METAL COMPOSITION (Wt%)**

C	Mn	Si	P	S
0.08	0.491	0.012	0.012	0.010

**TYPICAL ALL WELD METAL MECHANICAL PROPERTIES\***

YIELD STRESS	TENSILE STRENGTH	ELONGATION	CVN IMPACT VALUES
450 N/mm <sup>2</sup>	515 N/mm <sup>2</sup>	22%	72J @ 0°C

\* in "as welded" condition.

**OPERATIONAL AND PACKAGING DATA**

ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE * (amps)	PACKAGING (kg)	
			PKT	CTN
2.6	350	65 - 90	5	20
3.2	350	85 - 130	5	20
4.0	400	110 - 170	5	20
5.0	400	160 - 230	5	20

**Liability:** This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company Leeden Powerweld Sdn Bhd reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations, and specifications are for reference only and cannot be held liable for Leeden Powerweld Sdn Bhd.