

KOVET - M13

JIS Z3211 D4313

AWS A5.1 E6013

DIN 1913 E 43 21 R3

HIGH TITANIA TYPE

Characteristics and Applications:

KOVET - M13 is designed for high efficiency welding. Because of its thin flux coating the welding can be done with good slag removability, shallow penetration, less spatters, and beautiful bead.

KOVET - M13 is suitable for welding of vehicles, steel and other light structures.

Notes on Usage:

1. Don't exceed the range of proper current and weld with AC or DC.
2. Dry the electrodes at 70 ~ 100°C for 30 ~ 60 minutes.

Typical chemical composition of weld meta (wt%)

C	Mn	Si	P	S
0.068	0.35	0.36	0.022	0.012

Typical mechanical properties of weld metal

YP N / mm ²	TS N / mm ²	EL %	IV 0°C
362	467	26	

Sizes and recommended current range (AC or DC < + >)

Diameter (mm)		2.0	2.6	3.2	4.0	5.0
Length (mm)		300	350	350	400	400
Amps	F	40 ~ 60	60 ~ 90	100 ~ 120	110 ~ 160	160 ~ 220
	V&OH	40 ~ 60	50 ~ 80	80 ~ 100	110 ~ 150	140 ~ 200

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