



SATINCRAFT 13

45
OCV

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Yield Stress	460 MPa
Tensile Strength	520 MPa
Elongation	28%
CVN Impact Values	60J av @ 0°C.

TYPICAL ALL WELD METAL ANALYSIS:

C: 0.07% Mn: 0.60% Si: 0.50%

APPROVALS:

Lloyds Register of Shipping	Grade 2.
American Bureau of Shipping	Grade 2.
Det Norske Veritas	Grade 2.
American Bureau of Shipping	AWS A5.1 E6013.

- ▲ General Purpose, Rutile Type Electrode.
- ▲ Outstanding Operator Appeal!
- ▲ Versatile - All Positional Capabilities.
- ▲ Smooth Mitre Fillet Welds with Low Spatter.
- ▲ BLUE flux colour for instant I.D.
- ▲ General workshop, field and structural welding of mild or galvanised steel components such as pipes, tanks, frames, fences and gates etc.

Classifications:

AS/NZS 1553.1:	E4113-0.
AWS/ASME-SFA A5.1:	E6013.

Packaging and Operating Data:

AC (minimum 45 O.C.V.), DC+ or DC- polarity.

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Easyweld Handipaks	Part No
2.5	300	53	55 – 90	5kg	15kg – 3 x 5kg		611182
2.5	300	53	55 – 90	2.5kg	15kg – 6 x 2.5kg		612182
2.5	300	53	55 – 90	–	–	50 rod	322135
3.2	380	29	90 – 135	5kg	15kg – 3 x 5kg		611183
3.2	380	29	90 – 135	2.5kg	15kg – 6 x 2.5kg		612183
3.2	380	29	90 – 135	–	–	25 rod	322136
4.0	380	20	135 – 180	5kg	15kg – 3 x 5kg		611184

Easyweld Blister Pack:

10 x 2.5mm/5 x 3.2mm rod Satincraft Blue Blister Pak	322203
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WELDCRAFT

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OCV

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Yield Stress	420 MPa
Tensile Strength	490 MPa
Elongation	28%
CVN Impact Values	60J av @ -20°C.

TYPICAL ALL WELD METAL ANALYSIS:

C: 0.07% Mn: 0.60% Si: 0.50%

APPROVALS:

Lloyds Register of Shipping	Grade 3.
American Bureau of Shipping	Grade 3.
Det Norske Veritas	Grade 3.

- ▲ Rutile - Basic Type Electrode.
- ▲ Higher Radiographic Quality.
- ▲ Excellent Mechanical Properties.
- ▲ Versatile "Out-Of-Position" Capabilities.
- ▲ "On-site" and workshop welding where better mechanical properties are required and the work cannot be re-positioned to allow welding in the downhand. The electrode is recommended for welding joints subject to radiographic examination in pressure vessel, ship building, bridge and storage tank fabrications.

Classifications:

AS/NZS 1553.1:	E4113-2.
AWS/ASME-SFA A5.1:	E6013.

Packaging and Operating Data:

AC (minimum 50 O.C.V.), DC+ or DC- polarity.

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
2.5	300	51	60 – 95	5kg	15kg – 3 x 5kg	611202
3.2	380	27	95 – 135	5kg	15kg – 3 x 5kg	611203
4.0	380	17	130 – 185	5kg	15kg – 3 x 5kg	611204

MUREX™ SPEEDX 13

45
OCV

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Yield Stress	430 MPa
Tensile Strength	500 MPa
Elongation	28%
CVN Impact Values	60J av @ 0°C

TYPICAL ALL WELD METAL ANALYSIS:

C: 0.08% Mn: 0.43% Si: 0.35%

- ▲ Easy running E4113/E6013 general purpose electrode.
- ▲ For fillet and butt welding in all positions except vertical down.
- ▲ Self-lifting slag with low spatter loss.
- ▲ Recommended for welding thin sections of mild steel and galvanised steels.
- ▲ Easy to re-start.
- ▲ Is ideal for general purpose work such as frames, tanks, gates and light structural work.

Classifications:

AS/NZS 1553.1:	E4113-0.
AWS A5.1:	E6013.

Packaging and Operating Data:

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
2.5	300	55	60 – 90	5kg	15kg – 3 x 5kg	SP1325
3.2	380	30	90 – 135	5kg	15kg – 3 x 5kg	SP1332
4.0	380	19	135 – 180	5kg	15kg – 3 x 5kg	SP1340