

E6013

Conformance

AWS A5.1 E6013

Typical Application

• Suitable for welding structures made of low carbon steel, such as small size steel plates

Mechanical Properties

Tensile Strength (MPa)	Yield Strength (MPa)	Elongation (%)	Impact Energy (J)	Impact Temperature (°C)
485	380	28.5	86	0

Chemical Composition %

C	Mn	Si	S	P	Ni	Mo	Cr	V
0.079	0.38	0.21	0.018	0.024	0.020	0.005	0.032	0.010

Reference

Diameter (mm)	2.0	2.5	3.2	4.0	5.0
Type of Current	AC/DC ⁺				
Current(A)	40~70	60~100	80~140	140~220	180~230

E7018

Conformance

AWS A5.1 E7018

Typical Application

• Applied in low alloy steel and carbon steel welding structure

Mechanical Properties

Tensile Strength (MPa)	Yield Strength (MPa)	Elongation (%)	Impact Energy (J)	Impact Temperature (°C)
550	450	28	145, 149, 150	-30

Chemical Composition %

C	Mn	Si	S	P	Cr	Ni	Mo	V
0.07	1.05	0.46	0.015	0.011	0.01	0.02	0.031	0.017

Reference

Diameter (mm)	2.0	2.5	3.2	4.0	5.0
Type of Current	AC/DC ⁺				
Current(A)	40~70	50~90	80~140	110~210	160~230