



# PRODUCT DATA SHEET

## GENERAL PURPOSE ARC WELDING ELECTRODES

WCD 6102

### AUSTARC 13S



- ▶ General Purpose / Rutile Type Electrode
- ▶ Versatile / All Positional (especially vertical up) Capabilities
- ▶ Ideal for Downhand Fillet Welding of Mild Steel
- ▶ Smooth, Stable Performance on Low Voltage AC Welding Machines

#### Identification

**Coating** - Blue / White Stripe

**Tip** - Plain

**Imprint** - WIA 4313A

#### Classifications

AS/NZS 1553.1 E4113 Grade O (Superseded)

AWS A5.1 E6013

AS/NZS 4855 ISO 2560B E4313A\*

\*New classification replaces AS/NZS 1553.1

#### Description & Applications

AUSTARC 13S is the popular "blue and white striped" general purpose electrode for smooth mitre fillet welding applications. 13S has a soft and stable arc and produces flat, uniform fillet welds with ease and a self peeling slag action.

AUSTARC 13S is formulated primarily for fillet welding in all downhand positions. It is ideal for the general purpose and structural welding of sheet and plate steels (galvanised or otherwise) and tubular components, including trailers, duct work, hoppers and storage tanks, etc.

#### Operational Data

ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE * (amps)	ARC VOLTAGE RANGE (volts)**
2.0	300	40 - 60	19
2.5	300	60 - 85	20
3.2	380	100 - 130	21
4.0	380	140 - 180	22
5.0	450	180 - 230	23

\* Recommended for DC +/- or AC (minimum 45 OCV) operation.

\*\* Voltage is determined by arc current and electrode arc length. Arc voltage shown are typical and are only to be used as a guide.

#### Approvals

LRS 2M

ABS 2

DNV 2

#### Typical All Weld Metal Chemical Analysis

C	Mn	Si	Fe
0.07	0.55	0.45	Bal

#### Typical All Weld Metal Mechanical Properties

Yield Stress	450 Mpa
Tensile Strength	520 Mpa
Elongation	26%
CVN Impact Values	60J @ 0°C

In as welded condition.

#### Packaging Data

ELECTRODE SIZE (mm)	PACKAGING (KG)			APPROX NO OF RODS PER KG	PART NUMBER
	Packet	Carton	Minipak		
2.0	2.5	12.5	0.5	99	13S20 13S20M
2.5	2.5	12.5	1.0	63	13S25 13S25M
3.2	3.2	15	1.0	29	13S32 13S32M
4.0	4.0	15	-	19	13S40
5.0	5.0	15	-	10	13S50

#### Storage Information

Products should be stored in dry conditions in original sealed undamaged packaging as supplied. The integrity of consumable products can be adversely affected by time and storage conditions and that the detail shown in the batch certificate is true at the time of packaging and is only valid for a LIMITED time. After that time the product may need to be reconditioned or checked to ensure it is suitable for the purpose it is intended to be used for.\*

\*NOTE: Refer to Welding Technology Institute of Australia (WTIA), technical 3. care and conditioning of arc welding consumables.

#### Issue AB

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