

FOR CARBON STEEL

AWS E6012
JIS D4313
KS E4313

K-6012

Typical applications

Welding of shells of railway vehicles, cars, light vehicles and other steel structures and general light structural steels.

Coating

High titania type.

Characteristics on Usage

- ① Weld metal has a good bead appearance.
- ② The electrode diameter less than 3.2mm can be easily used in vertical-down welding.
- ③ Good X-ray quality.
- ④ Redry the electrode at 70~100°C for 30~60 minutes prior to use.

Typical chemical composition of all-weld-metal (%)

C	Si	Mn	P	S
0.09	0.26	0.46	0.015	0.012

Typical mechanical properties of all-weld-metal

Y · P N/mm ² {kgf/mm ² }	T · S N/mm ² {kgf/mm ² }	EI (%)	Charpy V-notch J {kgf · m} (0°C)
420 {43}	480 {49}	26	90 {9}

Sizes available and recommended currents (AC or DC ⊖)

Dia.	(mm)	2.6	3.2	4.0	5.0	6.0
Length	(mm)	350	350	400	400	450
Amp.	F	50~95	80~120	130~170	180~230	240~300
	V&OH	40~95	70~110	100~140	120~160	-

Welding positions



Approved by