

FOR CARBON STEEL

AWS E6013  
JIS D4313  
KS E4313

# KR-3000V

## Typical applications

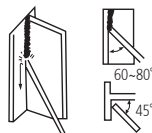
Welding of shells of railway vehicles, cars, light vehicles and other steel sheet structures and general light structural steels.

## Coating

High titania type.

## Characteristics on Usage

- ① In vertical-down welding, excellent bead appearance can be obtained by taking a little bit higher welding amperage and holding the electrode at the illustrated angles.
- ② Welding under excessive amperage conditions can cause the deterioration of radiographic soundness and other defects.



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

| C    | Si   | Mn   | P     | S     |
|------|------|------|-------|-------|
| 0.08 | 0.26 | 0.45 | 0.012 | 0.010 |

## Typical mechanical properties of all-weld-metal

| Y · P<br>N/mm <sup>2</sup> {kgf/mm <sup>2</sup> } | T · S<br>N/mm <sup>2</sup> {kgf/mm <sup>2</sup> } | EI<br>(%) | Charpy V-notch<br>J {kgf · m} (0°C) |
|---|---|-----------|-------------------------------------|
| 430 {44}  | 480 {49}  | 28        | 50 {5}                              |

## Sizes available and recommended currents (AC or DC ⊕, ⊖)

| Dia.   | (mm)   | 2.6    | 3.2     | 4.0     | 5.0     |
|--------|--------|--------|---------|---------|---------|
| Length | (mm)   | 350    | 350     | 400     | 400     |
| Amp.   | V-down | 80~120 | 100~150 | 150~200 | 210~250 |

## Welding positions



## Approved by

ABS, BV, LR, JIS, KS