

# LKE-6013



LINKWELD ALLOYS INC.

AWS	A5.1 E6013
EN	EN499 E 35 0 R 1 2
JIS	Z3211 D4313

## Characteristics:

LKE-6013 is designed for high efficiency welding. Because of its thin flux coating the welding can be done with good slag removability, shallow penetration, less spatters, and beautiful bead.

## Applications:

It is suitable for welding of vehicles, steel sheets and other light structures.

## Notes on Usage:

1. Don't exceed the range of proper current and weld with AC or DC.
2. Dry the electrodes at 80-100°C for 30~60 minutes.

## Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S
0.08	0.45	0.18	0.012	0.009

## Typical mechanical properties of weld metal

YP N/mm <sup>2</sup>	TS N/mm <sup>2</sup>	EL %	IV - 0 °c J
415	470	28	84

## Welding position:



## Sizes and recommended current range (AC or DC <+> )

Diameter (mm)		2.6	3.2	4.0	5.0
Length (mm)		300	350	400	400
Amps	F	60-90	100-120	110-160	160-220
	V&OH	50-80	80-110	100-150	140-200
Weight per pack(kg)		4/5	5	5	5
Weight per carton (kg)		20	20	20	20