



## MAC TRODE E6813-B2

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■ **Description & Applications:**

High purity rutile flux coating with specified alloyed additions extruded onto low S-P-Si ferritic core wire. Welding Cr – Mo steels of similar alloy levels when freedom from weld imperfections such as undercut is of equal importance to metallurgical properties, e.g. root runs, fillet welds.

■ **Related Specification:**

AWS E8013-B2

■ **Typical All Weld Metal Chemical Analysis %:**

C	Si	Mn	P	S	Cr	Mo
0.060	0.40	0.60	0.025	0.025	1.10	0.50

■ **Typical All Weld Metal Mechanical Properties:**

<u>As Welded</u>		<u>Minimum</u>	<u>Typical</u>
Tensile Strength	N/mm <sup>2</sup>	550	720
0.2% Proof Stress	N/mm <sup>2</sup>	460	640
Elongation on 4d	%	19	23
Reduction of area	%	-	75
Impact Energy 10°C	Joules	-	120
HV as welded		-	230

■ **Current:**

DC electrode positive (+) AC (OCV 70)

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm	6.00mm
70-110	100-150	140-210	200-280	250-350

■ **Storage:**

If allowed to become damp the electrodes should be re-dried for one hour at 150°C before use.