

## SATINCRAFT 13

### PRODUCT DATA SHEET



### GENERAL PURPOSE, RUTILE TYPE ELECTRODE

45  
OCV

DC  
AC

### MILD STEEL AND IRON POWDER ELECTRODES

#### SATINCRAFT 13

- General Purpose, Rutile Type Electrode.
- Outstanding Operator Appeal!
- Versatile - All Positional Capabilities.
- Smooth Mitre Fillet Welds with Low Spatter.
- Quite, Smooth Arc Action.
- BLUE flux colour for instant I.D.

#### CLASSIFICATIONS:

ISO AS/NZS: 4855

B E4313 A

AWS/ASME-SFA A5.1:

E6013

#### TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

|                   |              |
|-------------------|--------------|
| Yield Stress      | 460 MPa      |
| Tensile Strength  | 520 MPa      |
| Elongation        | 28%          |
| CVN Impact Values | 60J av @ 0°C |

#### TYPICAL ALL WELD METAL ANALYSIS:

|     |       |
|-----|-------|
| C:  | 0.07% |
| Mn: | 0.60% |
| Si: | 0.50% |

## DESCRIPTION AND APPLICATIONS:

Flat, horizontal-vertical, vertical-up and overhead - you can weld in any position with Satincraft 13.

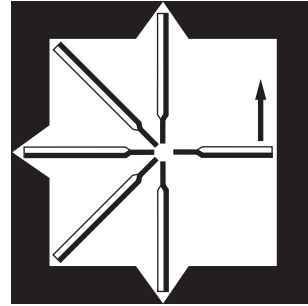
That's the beauty of Australia's most popular G.P. electrode.

Operating with either AC (min 45 O.C.V.) or DC current, Satincraft 13 produces smooth professional mitre fillet welds in all positions (except vertical-down) with very low spatter levels, positive re-strike (hot or cold) and self-releasing slag.

Applications include the general workshop, field and structural welding of mild or galvanised steel components such as pipes, tanks, frames, fences and gates etc. Satincraft 13 is particularly recommended for the lap and fillet welding of thin walled galvanised and mild steels where the low spatter levels and excellent edge wetting produce superior results.

## WELDING POSITIONS:

All positional - except vertical down.



## PACKAGING & OPERATING DATA:

AC (minimum 45 O.C.V.), DC+ or DC- polarity.

| ELECTRODE SIZE (MM) | LENGTH (MM) | APPROX NO. RODS/KG | CURRENT RANGE (AMPS) | PACKET          | CARTON           | HANG-TUBE PART NO. |
|---------------------|-------------|--------------------|----------------------|-----------------|------------------|--------------------|
| 2.5                 | 300         | 53                 | 55-90                | 5kg             | 15kg / 3 x 5kg   | 611182             |
| 2.5                 | 300         | 53                 | 55-90                | Half Pack 2.5kg | 15kg / 6 x 2.5kg | 612182             |
| 3.2                 | 380         | 29                 | 90-135               | 5kg             | 15kg / 3 x 5kg   | 611183             |
|                     |             |                    |                      | Half Pack 2.5kg | 15kg / 6 x 2.5kg | 612183             |
| 4.0                 | 380         | 20                 | 135-180              | 5kg             | 15kg / 3 x 5kg   | 611184             |



P/N: 611182



P/N: 611183



P/N: 611184



P/N: 612182



P/N: 612183

