

# PROWELD 4113 *For Mild Steel*

## Classification

AWS A 5.1 : E6013

## Approvals

LR

## Applications

Welding of thin to medium thick plates mild steel in general fabrication.

## Characteristics

PROWELD 4113 is a rutile coated general purpose mild steel electrode for a wide range in all positions welding. Easy striking and re-striking make the electrode very suitable for tack-welding. Beautiful bead appearance with soft arc and stable slag fluidity. Operation is especially easy on AC with low O.C.V.

## Typical Chemical Composition of Deposited Metal (%)

C	Si	Mn	P	S
$\leq 0.10$	0.20~0.40	0.30~0.60	$\leq 0.030$	$\leq 0.025$

## Typical Mechanical Properties of Deposited Metal

Tensile Strength N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	Yield Strength N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	Elongation %	Charpy 2V-notch at 29°C, J (kgf.m)
510 (52)	480 (49)	24	50 (5.1)

## Sizes & Recommended Current Range (AC or DC $\pm$ )

Diameter/ Length (mm)	2.0/250	2.6/350	3.2/350	4.0/350
Welding Position	Current (A)			
All	40~55	50~90	80~135	100~180

## Guideline in Usage

1. Use dry electrodes only. Damp electrodes should be re-dried at 80°C for 60 minutes before use.
2. Suitable for temperature of -10°C to +350°C.
3. Rust, mill scale, zinc, primers, etc. have to be removed.
4. PROWELD RU will operate on AC with low O.C.V.

## Welding Positions



*All positions*