

SMAW

AceWeld MS-13

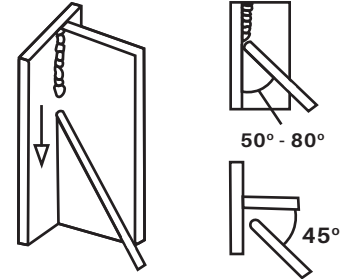
For Mild Steel

CLASSIFICATIONS: AWS A5.1 : E6013
 EN ISO 2560 - A : E 38 0 R 11
 EN ISO 2560 - B : E 43 13 A
 JIS Z3211 : E4313

WELDING
POSITIONS :



- **User Friendly Rutile Type Electrode**
- **All Positional Including Vertical Down Capabilities**
- **Easy Striking - Hot or Cold**
- **Stable Performance On All Home Welding Machine (D.I.Y)**



DESCRIPTION AND APPLICATIONS

AceWeld MS-13 is a high rutile type electrode designed for all positions welding. Smooth bead filler welding can be obtained with “Touch Welding” or short arc welding method in flat, horizontal and vertical positions. Features include:

- Extra arc force
- Quick freezing and easy slag release
- Low spatter and fume level
- Easy to start and restart with low voltage machine
- Ideal for vertical down fillet welding
- Suitable for A.C. or D.C. welding current supply

Application include the general workshop, structural steel or galvanised steel, water pipe, tanks, fences, furniture and gates etc. It is ideal for general purpose application and for welding thin plate, smaller size electrode it recommended.

TYPICAL ALL WELD METAL COMPOSITION (Wt%)

C	Mn	Si	P	S
0.07	0.40	0.35	0.012	0.015

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES

YIELD STRESS	TENSILE STRENGTH	ELONGATION	CVN IMPACT VALUES
435 N/mm ²	485 N/mm ²	28%	65J @ 0°C

- in “as welded” condition.

OPERATIONAL AND PACKAGING DATA

ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE(amps.)	PACKAGING (KG)	
			PKT	CTN
2.0	350	40 - 60	5	20
2.6	350	50 - 90	5	20
3.2	350	90 - 130	5	20
4.0	400	120 - 170	5	20
5.0	400	170 - 230	5	20

- Recommended for DC+ or AC (minimum 45 OCV) operation.