

SATINCRAFT 13

45
OCV

DC
AC

- ▲ 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.

APPROVALS:

Det Norske Veritas Grade 2.

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

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

Classifications:

AS/NZS 1553.1: (old) E4113-0.
AS/NZS 4855: (new) B E4313 A
AWS/ASME-SFA A5.1: E6013

TYPICAL ALL WELD METAL ANALYSIS:

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

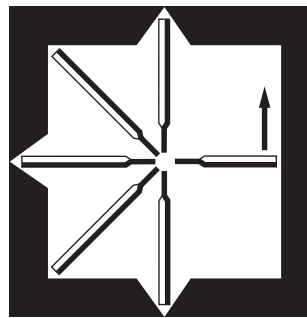
Description and Applications:

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.



All positional -
except vertical down

Packaging and Operating Data:

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

Electrode Size mm	Approx No. Length mm	Current Rods/kg	Range (amps)	Packet	Carton	Hang-tubePart 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
					12kg - 12 x 1kg	1kg 322135
3.2	380	29	90-135	5kg	15kg - 3 x 5kg	611183
				half pack 2.5kg	15kg - 6 x 2.5kg	612183
		25			12kg - 12 x 1kg	1kg 322136
4.0	380	20	135-180	5kg	15kg - 3 x 5kg	611184