

# PRODUCT DATA SHEET

## Oerlikon Fincord M



Medium coated, rutile type electrode especially suitable for light gauge sheet welding. When fillet welding, the Fincord M electrode can be kept in contact with the workpiece with no resultant excess convexity. Very little spatter loss. Smooth bead appearance.

### Re-drying Procedure

Provided that electrodes are stored in dry conditions, re-drying is not necessary.

### Classifications

#### Standards

AWS/ASME SF	A 5.1	E6013
EN	2560	E35 A R II

#### Electrode Marking

OER	6013	
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### Typical Chemical Analysis (All weld metal)

% Carbon	0,05	% Sulphur	0,02 max
% Manganese	0,5	% Phosphorous	0,02 max
% Silicon	0,45		

### Typical Mechanical Properties (All weld metal in the as welded condition)

0,2% Proof Stress	>360 MPa
Tensile Strength	450 - 560 MPa
% Elongation on 5d	>22
Impact Strength at +20°C	>60 J
Impact Strength at 0°C	>40 J

### Packing Data

Diameter (mm)	Current (A)	Electrode Length (mm)	Pack Mass (kg)	Pieces per Carton (approx.)	Item Number
2,5	60 - 90	350	5,0	250	W111002
3,15	90 - 140	350	5,0	170	W111003
4,0	120 - 190	350	5,0	106	W111004
5,0	160 - 240	450	5,0	69	W111005
6,3	200 - 290	450	5,0	32	W111006

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