

PRODUCT DATA SHEET

Oerlikon Fincord Plain



Heavy-coated rutile type electrode with outstanding welding characteristics. Suitable for the welding of light gauge steel sheets. Automatic re-striking, self-detaching slag, 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	P 6013	
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Typical Chemical Analysis (All weld metal)

% Carbon	0,08	% Sulphur	0,03 max
% Manganese	0,5	% Phosphorous	0,03 max
% Silicon	0,45		

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

0,2% Proof Stress	>380 MPa
Tensile Strength	510 - 610 MPa
% Elongation on 5d	>22
Impact Strength at +20°C	>60 J
Impact Strength at 0°C	>50 J
Impact Strength at -20°C	>25 J

Packing Data (42 V OCV min)

Diameter (mm)	Current (A)	Electrode Length (mm)	Pack Mass (kg)	Pieces per Carton (approx.)	Item Number
2,0	50 - 70	300	5,0	446	W111012
3,15	100 - 140	350	5,0	140	W111013
4,0	140 - 180	450	5,0	72	W111014
5,0	190 - 240	450	5,0	46	W111015

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