

SATINCRAFT 13

45
OCVDC
AC

- ▲ General Purpose, Rutile Type Electrode.
- ▲ Outstanding Operator Appeal!
- ▲ Versatile - All Positional Capabilities.
- ▲ Smooth Mitre Fillet Welds with Low Spatter.
- ▲ BLUE flux colour for instant I.D.

Classifications:

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

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.

APPROVALS:

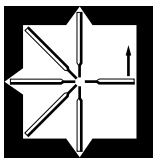
Lloyds Register of Shipping	Grade 2.
American Bureau of Shipping	Grade 2.
Det Norske Veritas	Grade 2.

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

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

TYPICAL ALL WELD METAL ANALYSIS:

C: 0.07%	Mn: 0.60%	Si: 0.50%
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All positional - except vertical down

Packaging and Operating Data:

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

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Hang-tube	Part 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

Blister Pack:

10 x 2.5mm/5 x 3.2mm	322203
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