

YAWATA RU *For Mild Steel*

Classification

AWS A 5.1 : E6013

Approvals

LR

Applications

Welding of thin to medium thick plates mild steel in general fabrication.

Characteristics

YAWATA RU is a rutile coated general purpose mild steel electrode for a wide range in all positions welding. Easy striking and re-striking make the electrode very suitable for tack-welding. Beautiful bead appearance with soft arc and stable slag fluidity. Operation is especially easy on AC with low O.C.V.

Typical Chemical Composition of Deposited Metal (%)

C	Si	Mn	P	S
≤0.10	0.20~0.40	0.30~0.60	≤0.030	≤0.025

Typical Mechanical Properties of Deposited Metal

Tensile Strength N/mm ² (kgf/mm ²)	Yield Strength N/mm ² (kgf/mm ²)	Elongation %	Charpy 2V-notch at 29°C, J (kgf.m)
510 (52)	480 (49)	24	50 (5.1)

Sizes & Recommended Current Range (AC or DC ±)

Diameter/ Length (mm)	2.0/250	2.6/350	3.2/350	4.0/350
Welding Position	Current (A)			
All	40~55	50~90	80~135	100~180

Guideline in Usage

1. Use dry electrodes only. Damp electrodes should be re-dried at 80°C for 60 minutes before use.
2. Suitable for temperature of -10°C to +350°C.
3. Rust, mill scale, zinc, primers, etc. have to be removed.
4. YAWATA RU will operate on AC with low O.C.V.

Welding Positions



All positions