

GMW R13

Standard:

AWS A5.1/ASME SFA-5.1 E6013

Technical Characteristics

The **GMW R13** is a true carbon steel “All-Position” electrode. It is specially developed for vertical down welding, where with other electrodes the molten slag tends to run ahead of the weld pool. Automatic slag removal, low levels of spatter and fumes, and excellent re-ignition are the main features of **GMW R13**. It produces spatter-free weld beads even under the most adverse conditions (rust and dirt) on all types of carbon steels.

Dimensions and Welding Parameters

DC(+) / DC(-) / AC

Diameter (mm)	Length (mm)	Current (A)
2,00	300	50 – 70
2,50	350	60 – 90
3,20	350	90 – 130
4,00	350	130 – 180
5,00	350/450	180 – 260

Typical Chemical Composition %

C	Si	Mn
0,06	0,30	0,40

Mechanical Properties (typical values)

Yield Strength	400 MPa
Tensile Strength	460 MPa
Elongation	28 %

The **GMW R13** exhibits excellent performance when used with small welding transformers characterized by low open-circuit voltage (OCV).

Welding Positions



All positions