ZIKA-11 LMN **E-6013** LOW MANGANESE EMISSION

CLASSIFICATION:

AWS A5.1: E 6013

EN ISO 2560-A: E 38 0 RR 1 2

DESCRIPTION:

We are proud to offer our **New Low Manganese** emission, rutile coated, welding electrode. This electrode was developed with the purpose of significantly reducing of the welders' exposure to hazardous manganese fume emission and to help our end-users meet increasingly demanding environmental regulation. The special weld metal composition of the Z-11-LMn provides the required mechanical properties and meets demands of international standards. The electrode is characterized by stable and smooth arc, easy slag detachability and excellent weld bead appearance.

APPLICATION:

Welding of general low carbon steel.

Coating Type: Rutile

Welding Current: DC-, AC

Welding Positions: all, besides vertical down

TYPICAL CHEMICAL COMPOSITIONS OF ALL-WELD METAL (WT-%)

C	Mn	Si	Ni	B	P	S	Fe
0.08	0.25	0.22	0.25	<0.001	<0.025	<0.02	bal.

TYPICAL MECHANICAL PROPERTIES OF ALL-WELD METAL

Yield Point (MPa)	UTS (MPa)	Elongation (%)	Impact Energy @0C°
430	**480**	**>26**	**>70**

WELDING PARAMETERS

Diameter (mm)	Electrode length (mm)	Current (A)
2.5	350	60-100
3.2	350	80-150
4.0	350/450	140-200