

## KR-3000

**AWS E6013**  
**JIS D4313**  
**KS E4313**

FOR CARBON STEEL

### Typical applications

Welding of all kinds of light constructional work in all positions, including pipe-welding.

### Coating

High titania type.

### Characteristics on Usage

- ① Excellent striking and restriking properties.
- ② Excellent slag removal and arc transfer.
- ③ Excellent bead appearance without undercut.
- ④ Redry the electrode at 70~100°C for 30~60 minutes prior to use.

### Typical chemical composition of all-weld-metal (%)

C	Si	Mn	P	S
0.07	0.32	0.45	0.015	0.012

### Typical mechanical properties of all-weld-metal

Y · P N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	T · S N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	EI (%)	Charpy V-notch J {kgf · m} (0°C)
430 {44}	480 {49}	29	70 {7}

### Sizes available and recommended currents (AC or DC ⊕, ⊖)

Dia.	(mm)	2.6	3.2	4.0	5.0	6.0
Length	(mm)	350	350	400	400	450
Amp.	F	60~100	80~130	130~180	160~220	210~280
	V & OH	60~90	80~120	90~140	120~190	-

### Welding positions



### Approved by

ABS, BV, CWB, DNV, GL, KR, LR, NK, JIS, KS