B-33 FAMILIARC™

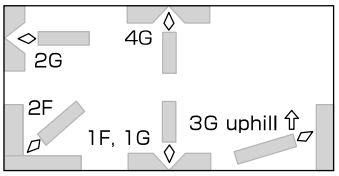
Stick electrode

Features: ▪ Excellent usability in the flat and horizontal positions

Classification: AWS A5.1 E6013

Redrying Conditions: 70~100℃x0.5~1h
Identification color: 1st Pink
Polarity: AC, DCEP, DCEN

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.0	300	2	20	10	270W, 85H, 330L
2.6	350	5	20	20	170W, 105H, 380L
3.2	350	5	20	30	170W, 105H, 380L
4.0	400	5	20	55	170W, 95H, 430L
5.0	400	5	20	82	170W, 100H, 430L
6.0	450	5	20	138	170W, 90H, 480L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.08	0.20
Si	0.30	1.00
Mn	0.33	1.20
P	0.013	0.035
S	0.009	0.035
Ni	0.01	0.30
Cr	0.02	0.20
Mo	<0.01	0.30
V	0.01	0.08

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.0	30~60	30~60
2.6	55~95	50~90
3.2	80~130	70~120
4.0	125~175	100~160
5.0	170~230	120~200
6.0	230~300	-

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	430	331min.
TS (MPa)	480	414min.
El on 4d (%)	25	17min.