Z-44 FAMILIARC™

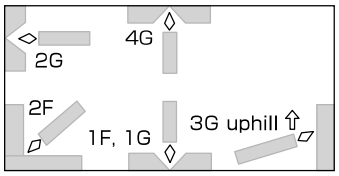
Stick electrode

Features: ▪ Typical lime titania type electrode

Classification: AWS A5.1 E6013

Redrying Conditions: 70~100℃x0.5~1h
Identification color: 1st Silver grey, 2nd Blue white
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	11	270W, 85H, 330L
2.6	350	5	20	22	170W, 105H, 380L
3.2	350	5	20	34	170W, 105H, 380L
4.0	450	5	20	64	170W, 90H, 480L
5.0	450	5	20	98	170W, 90H, 480L
6.0	450	5	20	142	170W, 90H, 480L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.08	0.20
Si	0.14	1.00
Mn	0.34	1.20
P	0.014	0.035
S	0.009	0.035
Ni	0.02	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	25~55
2.6	60~100	50~90
3.2	100~140	90~130
4.0	140~190	120~170
5.0	190~250	140~210
6.0	250~330	-

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	410	331min.
TS (MPa)	460	414min.
El on 4d (%)	32	17min.
IV 0℃ (J)	110	-

Approvals

ABS	3
LR	3m
DNV	3
BV	3
NK	KMW3