

CLASSIFICATION

EN ISO 3580 : E Mo R 22
AWS A5.5 : E8013-G

GENERAL DESCRIPTION

L-8013G is a rutile coated electrode. It gives a Mo alloyed weld metal that is used in the welding of boiler and pressure vessels operating under high temperatures.

APPROVALS

GOST, SEPRO, TSE

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Si	Mn	Mo
0.08	0.30	0.70	0.50

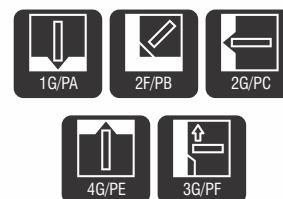
MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Yield Strength	: 500 N/mm ²
Tensile Strength	: 600 N/mm ²
Elongation (L=5d)	: 24 %
Impact (ISO-V)	: 50 J (+20°C)

WELDING PARAMETERS / PACKING AND DIAMETER INFORMATIONS / WELDING POSITIONS

Current Type and Polarity : DC (+)

Diameter [mm]	Length [mm]	Current [A]	Electrode Weight [g/100 pcs]	Box Weight [kg] Quantity [pcs/box]	Export Box Box Weight [kg]
2.50	350	75 - 110	2020	4.2 / 210	5
3.25	350	100 - 140	3380	5.1 / 150	5



APPLICATIONS AND MATERIALS TO BE WELDED

L-8013G is used for the welding of low alloyed and pressure vessel steels with a tensile strength up to 540 N/mm². It is ideal for the welding of boiler and pressure vessel steels and pipe connections that operate under temperatures up to 525°C. L-8013G, a basic coated electrode, should be preferred in multipass applications of thick sectioned or rigidly restrained mass structures.

	DIN	EN
Fine Grained Steels	StE 255 - StE 500 WStE 255 - WStE 500	S255N - S500N P255NH - P420NH
Pipe Materials	StE 320-7 - StE 415-7 StE 360-7 TM - StE 415-7 TM X52, X56, X60 (API 5LX)	L320 - L415NB L360MB - L415MB -
Boiler and Pressure Vessel Steels	H1, H11, H111 17 Mn 4, 19 Mn 5, 15 Mo 3 16 Mo 5	P235GH, P265GH, P285NH P295GH, P310GH, 16 Mo 3 -
Elevated Temperature Steels	St 35-8, St 45-8	P235G1TH - P255G1TH
Cast Steels	GS-45 GS-22 Mo 4 GS-C 25	GE240 G20Mo5 GP240GH

Liability : All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance.
Fumes : Consult information on Welding Safety Sheet, available upon request.

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