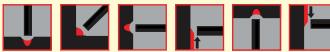
PRODUCT DATA SHEET

Oerlikon Fincord M













Medium coated, rutile type electrode especially suitable for light gauge sheet welding. When fillet welding, the Fincord M electrode can be kept in contact with the workpiece with no resultant excess convexity. Very little spatter loss. Smooth bead appearance.

Re-drying Procedure

Provided that electrodes are stored in dry conditions, re-drying is not necessary.

Classifications					
Standards					
AWS/ASME SF	A 5.1	E6013			
EN	2560	E35 A R 11			
Electrode Marking					
OER	6013				

Typical Chemical Analysis (All weld metal)					
% Carbon	0,05	% Sulphur	0,02 max		
% Manganese	0,5	% Phosphorous	0,02 max		
% Silicon	0,45				

Typical Mechanical Properties (All weld metal in the as welded condition)				
0,2% Proof Stress	>360 MPa			
Tensile Strength	450 - 560 MPa			
% Elongation on 5d	>22			
Impact Strength at +20°C	>60 J			
Impact Strength at 0°C	>40 J			

Packing Data							
Diameter (mm)	Current (A)	Electrode Length (mm)	Pack Mass (kg)	Pieces per Carton (approx.)	Item Number		
2,5	60 - 90	350	5,0	250	W111002		
3,15	90 - 140	350	5,0	170	W111003		
4,0	120 - 190	350	5,0	106	W111004		
5,0	160 - 240	450	5,0	69	W111005		
6,3	200 - 290	450	5,0	32	W111006		

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