

# SUPERMATIC

WITH POWDER IRON

WELDING ROD SPECIALLY FORMULATED FOR GENERAL PURPOSE APPLICATIONS IN PRODUCTION AND MAINTENANCE FOR THE METAL MECHANICAL LIGHT INDUSTRY. IT WORKS WITH EITHER LOW OR HIGH AMPERAGE

CLASSIFICATION A.W.S.: E-6013

IDENTIFICATION: GREY COATING

**APPLICATIONS:** For general maintenance and repair, for the production of equipment and machinery with low carbon steel. It is easy to work with and its slag is easily removed. The resulting weld seams have an excellent look. That is why SUPERMATIC is a versatile welding rod which can be used in all kinds of applications.

**CHARACTERISTICS AND PROCEDURE:** Its covering has been specially formulated so this electrode can be used with either low or high amperage. This makes this welding rod extremely versatile. It can be used in a wide range of applications. Its powder iron content gives it a performance rate which is far higher than that of other similar products of its kind. Consequently, you have to use fewer welding rods for a specific job. Powder iron also provides ease of application and a wider range of possibilities using high amperage since the welding rod does not get red hot in those jobs where high speed is required. SUPERMATIC is a welding rod which can be used in any kind of arc welding. Keep the arc short but do not let the welding rod tip contact the weld pool. Tilt the welding rod 45 ° in the same direction as the weld in flat welds. For horizontal fillet welding, tilt the welding rod between 30 and 45 ° with respect to the horizontal plane and at 80 ° in the same direction as the weld. In overhead welding, avoid excessive swinging from side to side; try to make the weld beads straight and intersecting one another.

<b>TENSILE RESISTANCE:</b>	4,710 - 5,000 KG./CM2 (67,000 A 71,100 PSI)
<b>ELASTIC LIMIT:</b>	4,200 - 4,600 KG./CM2 (59,725 A 65,410 PSI)
<b>ELONGATION IN 5 cm:</b>	25%
<b>BRINELL HARDNESS:</b>	160 BHN
<b>POSITIONS:</b>	ALL
<b>CURRENT:</b> :	AC or DC REVERSE POLARITY

FILLER METAL CHEMICAL ANALYSIS %					SIZES	AMPERAGE
<b>C</b>	<b>Mn</b>	<b>P</b>	<b>S</b>	<b>Si</b>	2.50 mm - 3/32"	65-90
0.10	0.60	0.03	0.03	0.30	3.25 mm - 1/8"	100-140
					4.0 mm - 5/32"	140-180
					5.0 mm - 3/16"	200-250