

# ARC Welding Electrodes

891 Group

Welding

## KENNEDY Electrodes for Mild Steels 6013

ARC welding rods for mild steel and medium tensile steels. Medium rutile coated, all positional rods.

**Applications:** for steel plate and strip including structural steels and pipe work, especially under site conditions. Superb finish with self-releasing slag.

**N.B.** Suitable for AC (50V minimum open circuit) and DC +/-.



**FOR MILD STEEL & C-Mn STEEL**

### Recommended Amperages

| Size (mm) | 2.5  | 3.2  | 4.0  |
|-----------|------|------|------|
| Min.      | 70A  | 95A  | 130A |
| Max.      | 100A | 125A | 170A |

Kennedy AWS 6013 mild steel electrodes are manufactured to the following standards:  
**Lloyds certificates:** BGK0610002/01, BGK0610002/02 & MATS/THA-1002/12/1.  
**ABS certificates:** BG575520-X3, BG575520-X2, BG575520-X4, BG575520-X5 & BG575520-X6.

| Size (mm)  | No. of Rods (per pack) | Weight (per pack) | Order Code KEN-891 | Price/Pk THB |
|------------|------------------------|-------------------|--------------------|--------------|
| 2.50 x 300 | 260                    | 5.0kg             | -3010K             | 1995.00      |
| 3.25 x 350 | 150                    | 5.0kg             | -3020K             | 1995.00      |
| 4.00 x 350 | 100                    | 5.0kg             | -3030K             | 2184.00      |

## Electrodes for Mild Steels

### E7018 ('Low Hydrogen')

Basic coated, all positional rods.

**Applications:** for steel plate structural steels, pipe work and forgings. Ideal for repairs of casting and machinery, compensate for dilution effect of poor steels.

Often used where rutile deposits may be at risk from cracking.

**N.B.** Suitable for AC (70V minimum open circuit) and DC-.

Optimum rooting operability is obtained using DC-.  
 Conforms with AWS and BS EN standards.



**FOR MILD STEEL & C-Mn STEEL**

### Recommended Amperages

| Size (mm) | 2.6  | 3.2  | 4.0  |
|-----------|------|------|------|
| Min.      | 70A  | 95A  | 130A |
| Max.      | 100A | 125A | 170A |

| Size (mm)  | No. of Rods (per Pk) | Weight (per Pk) | Order Code KEN-891 | Price/Pk THB |
|------------|----------------------|-----------------|--------------------|--------------|
| 2.60 x 300 | 260                  | 5.0kg           | -5110K             | 1848.00      |
| 3.20 x 350 | 150                  | 5.0kg           | -5120K             | 2037.00      |
| 4.00 x 450 | 100                  | 5.0kg           | -5130K             | 2184.00      |

## Electrodes For Cast Iron

A Graphite coated iron-nickel alloy electrode for high strength jointing of cast iron and cold welding of cast iron, it deposits 95%Ni + 2%Fe weld metal. Can be used for repairing broken cast iron, joining of cast iron to steel and building up worn parts.

Meets the following standards:

**AWS A 5.15 E Ni-C1**  
**Din 8573 E Ni BG 11.**



**FOR CAST IRON**



| Type  | Size (mm) | Recommended Amperage | Order Code KEN-891 | Price/Pk THB |
|-------|-----------|----------------------|--------------------|--------------|
| S-NFC | 2.5       | 70A                  | -1220K             | 7130.00      |
|       | 3.2       | 100A                 | -1230K             | 6920.00      |
|       | 4.0       | 145A                 | -1240K             | 6510.00      |

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