

Not just a weld.
It is a Perfect Pass.

Perfect Pass

Welding Products

Distributed by Agri Tool & Supply

713R

WIRE PRODUCT DATA SHEET

MICRO-ALLOY RUTILE
FLUX-CORED WIRE WITH
RAPIDLY SOLIDIFYING SLAG
FOR CO₂ AND AR-CO₂ MIX

APPLICATIONS

Use Perfect Pass 713R for shipbuilding, steel and pressure vessel construction, mechanical engineering, and pipe work.

PROPERTIES

Excellent weld puddle manipulation, thus superior all-position welding also at higher currents. Using temperature up to -40° C. Particularly suited for MAG-orbital welding and all position welding on ceramic backing. Low spatter loss, easy slag removal.

CLASSIFICATION

EN 758	T46 P C 1 H5 / T46 4 P M 1 H5
DIN 8559	SG R1 C Y 4643 / SG R1 M21 Y 4643
AWS/ASME-SFA-5.20	E 71 T-1

MATERIALS

SHIPBUILDING STEELS	A, B, D, E, AH 32 TO EH 36	
UNALLOYED STRUCTURAL NEEDS	ST 33, ST 37-2 TO ST 52-3	DIN 17 100
BOILER STEELS	H I, H II, 17 MN 4	DIN 17 155
PIPE STEELS	ST 37.0 TO ST 52.0	DIN 1626/1629
	ST 37.4 TO ST 52.4	DIN 1628/1630
	ST 35.8 TO ST 45.8	DIN 17 175
	STE 290.7 TM TO STE .7 TM	DIN 17 172
STEELS TO API-STANDARD	X 42 TO X 70	API-STANDARD

APPROVALS

TUV, DB, GL, CONTROLAS, BV, LR, DNV, RINA, PRS, FORCE, ABS

ALL WELD METAL ANALYSIS % (TYPICAL WELDING PARAMETERS)

C	MN	SI	P	S
0,05	1,3	0,5	<0,015	<0,015

MECHANICAL PROPERTIES OF ALL WELD METAL (TYPICAL VALUES)

HEAT TREATMENT	R _{p0.2} [N/MM ²]	R _m [N/MM ²]	A ₅ [%]	CHARTPY V NOTCH [J]	
				-20°C(CO ₂)	-40°C(AR-CO ₂)
AW	> 460	550-650	> 22	> 60	> 60

CURRENT
POLARITY
= +

WELDING
POSITION
↑ ↓ ← →