Technical data sheet 210314	SMAW electrode # SPEEDARC 6013-E	Welding Alloys Group

CLASSIFICATION

AWS A5.1	E6013
ISO 2560-A	E 42 0 RC 11
ISO 2560-B	E 43 13 A

DESCRIPTION AND APPLICATIONS

- Rutile electrode designed for all-position welding
- Easily detachable slag
- Very good bead appearance, with concave fillet free of undercut
- Instantaneous striking and restriking

APPLICATIONS

Construction steels for general use, Tube steels, Ship steels, Steels for Boiler and Pressure Vessels, High strength steels, Heat resisting steels, Cold tough steels

Examples

Unalloyed construction steels	EN 10025	S235JRG1 to S355J2G3
Boiler plate	EN 10028-2	P235GH to P355GH
Fine-grained steels	EN 10028-3	P275N to P420N, P275NL to P420NL
	EN 10113	S275N to S420N, S275NL to S420NL
Pipe steels	EN 10208	L240NB to L415NB
	API 5L	X42, X46, X52, X60
Pressure vessel plates	ASTM SA516	Gr55 to Gr70
Shipbuilding steels	A, E, A32-F40	
Cast steels	DIN 1681	GS-38, GS-45, GS-52
	IS/TR 15608: Groups 1.1, 1.2, 1.3, 2.1 and 3.1	

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Si	Mn	P	S
<0.1	0.45	0.6	<0.02	<0.02

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp 0.2% [MPa]	A5 [%]	CVN [J]
430	330	17	-

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp 0.2% [MPa]	A5 [%]	CVN [J]
520	460	24	-10°C: 50J

OPERATING CONDITIONS

Electrode ØxL [mm]		2,5 x 350	3,2 x 350	4,0 x 350
Current [A]		60 - 90	90 - 130	125 - 180
= +	~ 40V			

WELDING POSITIONS

EN ISO 6947: PA, PB, PC, PF, PE
ASME IX: 1G, 2F, 2G, 3G, 4G

PACKAGING

Electrode ØxL [mm]	2,5 x 350	3,2 x 350	4,0 x 450
Weight/box [kg]	5	5	6.5

Other packaging and other diameters: please consult us