

**Technical data sheet**

210314

**SMAW electrode  
SPEEDARC 6013-E****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

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.