

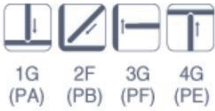
## E6013

AWS A5.1 E6013  
 ISO2560-A-E38 0 RC 11  
 GB/T 5117 E4313

### Description:

It is a rutile type general purpose electrode for all positional welding. Suitable for welding of low carbon steel structure, especially for the welding of thin plate steel with short discontinuous weld and requirement of smooth welding pass. AC & DC.

### Welding Position:



### Diameters:

1.6mm, 2.0mm, 2.5mm, 3.2mm, 4.0mm, 5.0mm.

### Typical Mechanical Properties:

Tensile strength(MPa):	490
Yield strength(MPa):	396
Elongation (%):	26
Impact values( $\geq 47$ )/(-20°C):	82

### Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	V
0.08	0.43	0.026	0.021	0.21	0.04	0.011	0.007	0.009

### Welding Current: (AC/DC+)

Diameter(mm)	2,5	3,2	4,0	5,0
Current/A	F/H 60-90	80-130	150-190	180-250
Current/A	V/OH 50-80	80-110	130-170	--

### Note:

No need to bake before using, but please bake 30-60 minutes in 150°C if the electrodes is humid.