

6013 T

CATEGORY SMAW Stick Electrodes

TYPE Thick coated rutile electrode for SMAW welding

APPLICATIONS Yacht building, wagon building, train, ship building, vessel, general constructions

PROPERTIES 6013 T is a thick coated electrode for joining and surfacing steel structures of all kinds in mechanical engineering, body and wagon building, in the fabrication of vessels and containers, and in shipbuilding. The 6013 T is eminently weldable and possesses excellent welding properties in all positions except vertically down. Easy strike, no spatter losses. Very easy slag removal. Smooth, finely rippled seam surface and low fume.

CLASSIFICATION

AWS	A 5.1: E 6013
EN ISO	2560-A: E 42 0 RR 12
DIN	1913: E 51 22 RR 6

SUITABLE FOR

DIN:	-	W.Nr.:	
Unalloyed steels:	St 33 to St 52.3	1.0035 to 1.0570	
Boiler plates:	HI, HII, 17 Mn4	1.0345, 1.0425, 1.0481	
Pipe steels:	St 35 to St 52.4	1.0308 to 1.0581	
-	StE 210.7 to StE 360.7	1.0307 to 1.0582	
Shipbuilding plates:	A, B, D	1.0440, 1.0472, 1.0475	
Steel castings:	GS-38 to GS-52	1.0416 to 1.0551	
Thin sheets:	1623/1		

APPROVALS TUV, CE approved

WELDING POSITIONS:



WELD METAL WEIGHT %

C	Mn	Si	Cr	Ni	Mo
0.08	0,6	0.45	-	-	-

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				0°C	-40°C	-60°C	
AW	>360	510-610	>22	>47			

AW: as welded

WELDING PARAMETERS PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A)	kg / can	kg / 6pack	kg / 1000
2,0	300	50-70	2.2	13.2	11.1
2,5	300	65-90	2.6	15.6	20.46
3,2	350	100-140	2.6	15.6	34.78
4,0	450	140-180	3.2	19,2	72
5,0	450	190-240	3.1	18.6	105.9
6,0	450	240-290	3.0	18	150

REDRYING TEMPERATURE 140°C / 2hr