

S-6013.V

Type : Rutile-Cellulosic



Conformances

AWS A5.1/ ASME SFA5.1 E6013
 JIS Z3211 E4313
 EN ISO 2560-A-E38 0 RC 1 1
 KR 2
 ABS 2
 LR 2
 NK KMW2
 TÜV EN ISO 2560-A-E38 0 RC 11
 DB EN ISO 2560-A-E38 0 RC 11
 CWB CSA W48 E4313
 CE

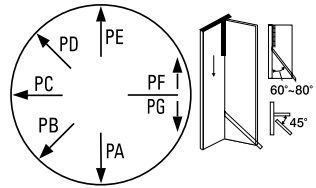
Applications

- General fabrication

Features

- Suitable for butt and fillet welding of thin plates
- Good at vertical down
- Good restriking
- Good bead appearance
- Easy to remove slag

Welding Position



Current

AC or DC ±

Redrying Conditions

70~100°C (158~212°F) X 0.5~1hr

Diameter / Packaging

Diameter mm (in)	Length mm (in)	Standard	
		packet 5kg(11lbs)	carton 20kg(44lbs)
2.6 (3/32)	350 (14)		√
3.2 (1/8)	350 (14)		√
4.0 (5/32)	400 (16)		√
5.0 (3/16)	400 (16)		√

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.09	0.32	0.48	0.017	0.012

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.-lbs)
451 (65,395)	497 (72,065)	27.5	0 (32)	65 (48)

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	350 (14)	350 (14)	400 (16)	400 (16)
F & HF	60~100	100~140	140~190	190~240
V-up, OH	45~90	60~120	100~160	120~220