

## 6013 Fall

**CATEGORY** SMAW Stick Electrodes

**TYPE** Rutile celulosic electrode for welding in all positions

**APPLICATIONS** This electrode is specially developed for maintenance and repair in shipbuilding and ship repair as also for similar jobs and or bad prepared seams in other constructions.

**PROPERTIES** The weld puddle is amazingly fast freezing and therefore especially preferred in vertical down position with high speed and deep penetration. Due to the wood powder based coating the weld puddle is super fast freezing and therefore amazing results can be achieved on old and dirty or otherwise diluted plates.

**CLASSIFICATION**

AWS	A 5.1: E 6013
EN ISO	2560-A: E 38 0 RC 11
DIN	1913:E 43 22 R(C)3

**SUITABLE FOR**

Steel type:	DIN:	W.Nr.:
Unalloyed steels:	St 33 to St 52.3	1.0035 to 1.0570
Boiler plates:	Hl, Hll, 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** CE approved

**WELDING POSITIONS:**



**WELD DEPOSIT WEIGHT %**

C	Mn	Si	Cr	Ni	Mo
0.08	0.6	0.4	-	-	-

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				20°C	-40°C	-60°C	
AW	>360	470-600	>22	>47			

AW: as welded

**PARAMÈTRES DE SOUDAGE / EMBALLAGE**

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) DC+/-/AC	kg / can	kg / 6pack	kg / 1000
2,5	350	55-85	2.4	14.4	14.9
3.2	350	90-140	2.6	15.6	34.4
4.0	350	130-180	2.6	15.6	44.9
5.0	350	180-230	2.8	16.8	89.6

**REDRYING TEMPERATURE** 120°C/1hr