SC 6013

Mild steel electrode

Classification

AWS A5.1: E 6013	EN ISO 2560-A: E 38 0 R 12

Description and applications

Rutile type medium coated electrode, used for the welding of large structures and process pipe work in the shipbuilding and construction industries where precise fit-ups are difficult to achieve. SUPER OPTIMAL 6013 is a high quality electrode designed to give high impact toughness properties. The electrode formulation promotes a forceful arc to ensure sound fusion and is tolerant to variations in welding current, which are important considerations when welding under site conditions.

- Rutile medium-heavy coated, finely rippled smooth weld beads.
- Very soft arc, minimum spatter, smooth fine rippled radiographic weld bead.
- Superior slag detachability.
- Excellent impact notch toughness at 0°C.

Base materials

S(P)235 to S(P)355; GP240-GP280.

All weld metal mecanical properties (typical)

Heat Treatment	Tensile strength Rm (N/mm2)	Yield strength Rm (N/mm2)	Elongation A5 (%)	Impact energy ISO- V (J) 0°C	Hardness
As welded	470-540	≥380	≥24	≥70	--

Typical weld metal chemical composition (%)

C	Si	Mn	P	S
0.07	0.20	0.50	0.03	0.03

Amperes (A)

2.50	3.15	4.00	5.00
60-80	110-135	160-180	180-230

Storage and redrying

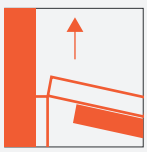
Keep dry and avoid condensation. Re-drying not generally required. If necessary : 100-110 °C for 1 hour.

Welding positions

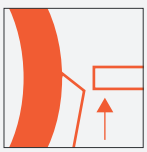

1G/PA


2F/PB


2G/PC


3G/PF


4G/PE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