Key Facts

- Re-striking
- Tack welding
- Very easy to weld with
- Beautiful bead appearance

Description

A rutile coated electrode used for all general fabrication work where the best appearance is required, they are easy to weld with good bead appearance.

General purpose mild steel electrode designed for thin sheet metal or light gauge steel but with sufficient penetration for welding medium gauge steels.

Excellent operating characteristics when using small diameter electrodes at lower amperage and with lower open- circuit AC voltage.

Used in all-positions including vertical downward and overhead. This electrode is one of the easiest to use because of its wide operating range and restrike characteristics.

Soft, steady and quiet arc, low spatter and a slag that seems to peel away. This electrode gives off very little smoke or fumes - giving it superb operator appeal.

Commonly used on many mild, low alloy and medium carbon steels, including tack welds on thin sheet metal, automobiles, metal furniture, farm equipment, window frames, iron grills, fences, storage tanks and general construction.

Classification

AWS A5.1: E6013

Welding Positions

Flat, horizontal, vertical-up, vertical-down and overhead.

Markings & Identification

End tip Colour: Blue
End side Colour: Red
Printing: E 6013

Applications

This electrode is suitable for structural steel, plate, sheet steels, tubular sections or any general steel application. Ideal for tack welding and multiple short-run welds. Also used for container and storage vessels and for rolling stock construction.



Typical All Weld Metal Analysis

C - Carbon	Mn - Manganese	Si - Silicon
0.070%	0.300%	0.200%

Typical All Weld Metal Mechanical Properties

Yield Strength:	430 MPa
Tensile Strength:	490 MPa
Elongation (5xD):	24%
Reduction of Area:	50%
Impact Strengths ISO-V	80J @ +20°C 50J @ 0°C

Packaging & Ordering Information

Size	Packet	Ctn	Current Range	Part Number
2.0mm	2kg	20kg	30-70	100029
2.0mm	6stk		30-70	100029H
2.6mm	2kg	20kg	50-90	100030
2.6mm	6stk		50-90	100030H
3.2mm	5kg	20kg	90-130	100031
3.2mm	6stk		90-130	100031H
4.0mm	5kg	20kg	110-170	100032

Disclaimer: The above information is provided as a guide; actual welding current and voltage will depend on the welding machine characteristics, which will vary from model to model. Other variables include run length and size, plate thickness, operator technique and gas type (if used). The user must evaluate the process, application and recommended professional advice. Under no circumstance will Dynaweld or its affiliates be liable for misuse or application of products this is entirely up to the user's ability.