

6013

GENERAL PURPOSE WELDING ROD FOR LOW CARBON STEEL. IT IS MILD AND STABLE. GOOD FINISH.
SLAG COMES OFF EASILY. VERY SHORT ARC AND VERY LITTLE SPLATTERING.

CLASSIFICATION A.W.S.: E-6013

IDENTIFICATION: GREEN COATING

APPLICATIONS: For general maintenance and repairs. For the production of equipment and machinery with low carbon steel. Its application is very easy with metal sheets as in metal furniture and car bodies. Its slight penetration and filler metal quick hardening make both easy to control so it allows welding in the most difficult positions.

CHARACTERISTICS AND PROCEDURE: 6013 works with DC reverse polarity or with AC in any welding position, including overhead. Its arc is quiet and perfectly stabilized with little penetration.

Since its filler metal and slag harden quickly, the welder has outstanding control over both. This makes welding in the most difficult positions and with very wide joints, possible.

Its filler metal can be peened while hot. 6013 is widely used to weld all kinds of joints for production and maintenance. It is specially recommended for those jobs where very smooth, nice looking welds are required.

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| TENSILE RESISTANCE: | 4,710 - 5,000 KG./CM2 (67,000 A 71,100 PSI) |
| ELASTIC LIMIT: | 4,200 - 4,600 KG./CM2 (59,725 A 65,410 PSI) |
| ELONGATION IN 5 cm: | 25% |
| BRINELL HARDNESS: | 160 BHN |
| POSITIONS: | ALL |
| CURRENT: | AC or DC REVERSE POLARITY |

| FILLER METAL CHEMICAL ANALYSIS % | | | | | SIZES | AMPERAGE |
|----------------------------------|-----------|----------|----------|-----------|-----------------|----------|
| C | Mn | P | S | Si | 2.25 mm - 3/32" | 65-90 |
| 0.10 | 0.60 | 0.03 | 0.03 | 0.30 | 3.25 mm - 1/8" | 100-140 |
| | | | | | 4.0 mm - 5/32" | 140-180 |
| | | | | | 5.0 mm - 3/16" | 200-250 |