

Weld 6013

General purpose, easy to use rutile electrode with good slag detachability. Suitable for all welding positions except vertical down.

Specifications

Classifications	SFA/AWS A5.1 : E6013 EN ISO 2560-A : E 35 0 RA 12
Approvals	ABS : 2 BKI : 2 LR : 2
Industry	Industrial and General Fabrication Mobile Equipment Ship/Barge Building

Welding Current	AC, DC+
Alloy Type	Carbon Manganese
Coating Type	Rutile-acid covering

Deposition Data

Diameter	Amps	Volts	Efficiency (Per)	Number of electrodes/kg weld metal	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
2.5 x 350.0 mm	50-90 A	24 V	59 %	100	51 sec	0.7 kg/h
3.2 x 350.0 mm	80-130 A	26 V	53 %	60	64 sec	0.9 kg/h
4.0 x 400.0 mm	150-200 A	25 V	56 %	32	83 sec	1.4 kg/h
5.0 x 400.0 mm	180-240 A					0.0 kg/h