



GENERAL PURPOSE RUTILE ELECTRODE -- AWS/ASME SFA - 5.1 E6013

Characteristics

Suitable for joining and repair welding of light steel fabrications, iron works, wrought iron works, agricultural machines, boiler, chassis of vehicles. Suitable for all position except vertical-down. Particularly suited for the welding of horizontal fillets. Very smooth weld bead appearance, with easy arc striking and re-striking properties, quite and stable arc with fine-droplet metal transfer. Possible to use equally well both with AC and DC. Slag is completely self-releasing.

Base Material



Typical applications

Suitable for joining and repair welding of light steel fabrications, iron works, wrought iron work



Typical Analysis in %

	%C	%Mn	%Si	%S	%P
Typical Chemical Analysis	0.06	0.55	0.40		
	%Cr	%Ni	%Mo	%Cu	%Ti

Mechanical Properties as required per AWS A5.28 ER100S-1

	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elongation A5 %	Impact Energy J
Typical Results (all weld metal)				
As Welded	500 mpa	560 mpa	28	0C 50 J

Ordering Information

Article Number	Product	Dimension	Packaging
1113010M15	ESR 13 (E6013)	2.5x350mm(3/32X14")	3X5 KG (3X11 lb) Cardboard
1113016M15	ESR 13 (E6013)	3.25X350mm(1/8X14")	3X5 KG (3X11 lb) Cardboard
1113020M15	ESR 13 (E6013)	4.0X350mm(5/32X14")	3X5 KG (3X11 lb) Cardboard
1113032M15	ESR 13 (E6013)	5.0X350mm(3/16X14")	3X5kg (3X11 lb) Cardboard

