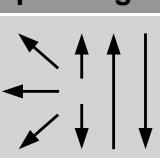


Classification						
EN ISO 2560-A	EN ISO 2560-B	AWS A5.1	AWS A5.1M			
E38 0 RC 1 1	E4313 A	E6013	E4313			
Characteristics and typical fields of application						
Rutile-cellulosic coated electrode with good weld ability in all positions including vertical-down. Most popular E 6013 type.						
For small welding machines, very good operating characteristics, flexible coating, good for tack welding. Versatile applications in structural welding, vehicle construction, boiler and tank welding, and in shipbuilding, also suitable for galvanised components.						
Base materials						
Steels up to a yield strength of 380 MPa (52 Ksi) S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, ship building steels: A, B, D ASTM A 106, Gr. A, B; A 283 Gr. A, C; A 285 Gr. A, B, C; A 501, Gr. B; A 573, Gr. 58, 65; A 633, Gr. A, C; A 711 Gr. 1013; API 5 L Gr. B, X42, X52						
Typical analysis of all-weld metal (wt.-%)						
	C	Si	Mn			
wt.-%	0.06	0.4	0.45			
Mechanical properties of all-weld metal						
Condition	Yield strength R <sub>e</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J		
	MPa	MPa	%	+20 °C	±0 °C	-10 °C
u	<b>460</b> (≥ 380)	<b>490</b> (470 – 600)	<b>25</b> (≥ 20)	<b>75</b>	<b>60</b> (≥ 47)	<b>47</b>
u untreated, as welded						
Operating data						
	Polarity:	Redrying	Electrode identification:	∅ (mm)	L mm	Amps A
	DC (-)	not necessary	FOX OHV 6013	2.0	250	45 – 80
	AC		E 38 0 RC	2.5	250/350	60 – 100
				3.2	350	90 – 130
				4.0	350/450	110 – 170
			5.0	450	170 – 240	
Approvals						
TÜV (5687.), DB (10.014.12), ABS (2), DNV (2), LR (2), LTSS, SEPROZ, CE						