



## PRODUCT INFORMATION

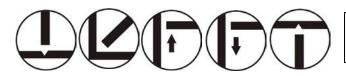
## **WELDABILITY 6013-M**

AWS A5.1 E 6013 EN ISO 2560 E 42 0 11

## **DESCRIPTION**

Weldability 6013-M is a versatile and general purpose rutile-coated mild steel MMA electrode which runs smoothly and leaves an attractive weld bead. Weldability 6013-M can be confidently used on land-based steel structures and general fabrication alike.

### **WELDING POSITIONS**



Suitable for easy use in all popular welding positions, Weldability 6013-M offers a smooth arc, low spatter and easy-lifting slag to reveal a finely-rippled bead.

## **TYPICAL WELD METAL COMPOSITION**

С	0.07 %
Mn	0.40 %
Si	0.40 %
S	0.01 %
Р	0.02 %

## **TYPICAL MECHANICAL PROPERTIES**

0.2% Yield Strength	≥ 420 N/mm2
Ult Tensile Strength	≥ 520 N/mm2
Elongation	~ 24%
Impact Values ISO-V	0° <u>&gt;</u> 50J

# **MATERIAL TO BE WELDED**

Weldability 6013-M is ideal for both butt and fillet joints in a broad variety of general fabrication and repair tasks, including platework, pipe flanges, frames and tubes, as well as construction, structural steels and pressure vessels. It can be used in DC+, DC- or AC (min OCV 50V) currents/polarities, and should be re-dried at 100°C for 1hr if required.

## **AVAILABLE FORMATS**

ELECTRODE RODS (MMA / SMAW)			
Dia	5.0kg Pkt	Approx Pcs/Pkt	
2.5mm	TX652550	265	
3.2mm	TX653250	170	
4.0mm	TX654050	115	

CURRENT RANGE		
Dia (mm)	Amps	
2.5	60 – 100	
3.2	85 – 130	
4.0	130 – 170	

Doc Ref: WELDABILITY/PI/TX652550

For further information, contact Weldability | Sif technical support on 0870 330 7757 or email service@wholeweld.co.uk

