

### ARC WELDING ACCESSORIES



PICTURE FILE: TX60132550

#### PART NUMBERS

TX60132050  
TX60132550  
TX60133250  
TX60134050  
TX60135050

#### PRODUCT DESCRIPTIONS

##### WELDABILITY 6013 MMA ELECTRODES

2.0MM 5KG PACK  
2.5MM 5KG PACK  
3.25MM 5KG PACK  
4.0MM 5KG PACK  
5.0MM 5KG PACK

#### PRODUCT DESCRIPTION:

Weldability 6013 general purpose mild-steel electrodes are of the all-position 6013 type and perform well in all sorts of applications including ship-building, sheet-metalwork and general light fabrication.

Weldability 6013 establishes a smooth, quiet, medium penetrating arc that is readily maintained with minimal spatter loss. The slag lifts easily, revealing a finely rippled bead contour.

Weldability 6013 is available in 2.0mm, 2.5mm, 3.25mm, 4.0mm and 5.0mm sizes, packed in 5.0kg packs and then in 15kg cartons, and works well in many conditions, even with small AC power sources having low open-circuit voltage (min 50v).

Weldability 6013 will operate on AC or DC reverse polarity current.

#### TECHNICAL SPECIFICATIONS:

Conforms to AWS A5.1 (E6013); DIN 1913 and EN 499.

#### MECHANICAL PROPERTIES:

Tensile strength : 530 N/mm<sup>2</sup>  
Yield strength : 460 N/mm<sup>2</sup>  
Elongation % : 25  
Impact Value (J): 60 J (0° C)

Diameter		3/32" (2.5mm)	1/8" (3.2mm)	5/32" (4.0mm)
Amperage	F	55 – 90	80 – 130	120 – 180
	V-OH	45 – 80	70 – 100	100 – 150

Carbon	Managanese	Silicon
0.08	0.50	0.40

#### NOTES:

Weldability E6013 meets the approvals of LRS, GL, BV, DnV, TL and TSE.

6013 is just one product in a wide and diverse variety of Consumables, Accessories, Equipment and Safety Wear products that make up the Weldability range.

#### ALTERNATIVES:

**TEL: 01462 482200 FAX: 01462 482202 EMAIL: [sales@wholeweld.co.uk](mailto:sales@wholeweld.co.uk)**  
**VISIT THE WELDABILITY WEBSITE AT: <http://www.weldability.com>**