

PRODUCT INFORMATION

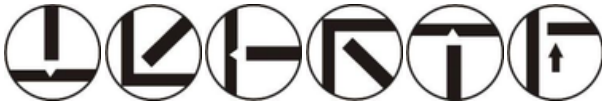
STAVINOX 6013

AWS A5.1: E6013
EN ISO 2560-AE 38 0 R 1 2

DESCRIPTION

STAVINOX 6013 is a general-purpose, rutile-coated mild steel MMA electrode, coated with a medium layer of rutile, producing a finely rippled and smooth weld bead. It offers exceptional slag detachability and excellent impact notch toughness at 0°C, with strong arc forces, minimal spatter and a radiographic-quality weld bead, making it well suited to general fabrication and repair work.

WELDING POSITIONS



Suitable for all welding positions (AC; DC±). STAVINOX 6013 offers a stable arc, excellent re-strike/striking capability and easy-lifting, self-detaching slag.

TYPICAL WELD METAL COMPOSITION

C	0.20 Max	Cr	0.20 Max
Si	1.00 Max	Ni	0.30 Max
Mn	1.20 Max	Mo	0.30 Max
S	N.S	V	0.08 Max
P	N.S		

TYPICAL MECHANICAL PROPERTIES

Yield Strength Ult	>330 N/mm ²
Tensile Strength	>430 N/mm ²
Elongation	>22%
Impact Values ISO-V	N.S

MATERIAL TO BE WELDED

STAVINOX 6013 is suitable for general fabrication and repair tasks across mild steel structures, platework, frames and tubes. Root weldability is verified, with a maximum wall thickness of 40mm. Current/polarity: DC+ or AC. Highest short-term operating temperature 350°C; lowest operating temperature ±0°C, as for parent metal. (Source: TÜV-Verband Welding Consumable Leaflet 20145.01, dated 08.11.2024.)

AVAILABLE FORMATS

RE802550-SV	2.5mm 5kg
RE803250-SV	3.2mm 5kg
RE804050-SV	4.0mm 5kg
RE805050-SV	5.0mm 5kg

For further information, contact Weldability-SIF on +44 1462 482200 or email orders@weldability-sif.com



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