


CEWELD E 6013 T

TYPE	Thick coated rutile electrode for SMAW welding. (Type E 42 0)																				
APPLICATIONS	CEWELD® E 6013 T is a thick-coated electrode for joining and applying steel structures of all kinds in mechanical engineering, car body and wagon construction, tank and container construction and shipbuilding.																				
PROPERTIES	CEWELD® E 6013 T is a thick coated electrode for joining and surfacing steel structures of all kinds in mechanical engineering, body and wagon building, in the fabrication of vessels and containers, and in shipbuilding. The CEWELD® E 6013 T is eminently weldable and possesses excellent welding properties in all positions except vertically down. Easy strike, no spatter losses. Very easy slag removal. Smooth, finely rippled seam surface and low fume.																				
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.1: E 6013</td> </tr> <tr> <td>EN ISO</td> <td>2560-A: E 42 0 RR 12</td> </tr> <tr> <td>F-nr</td> <td>2</td> </tr> <tr> <td>FM</td> <td>1</td> </tr> </table>	AWS	A 5.1: E 6013	EN ISO	2560-A: E 42 0 RR 12	F-nr	2	FM	1												
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F-nr	2																				
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SUITABLE FOR	<p>Rp < 420 MPa (60ksi) ISO 15608: 1.1 ReH < 275 MPa, 1.2 275 < ReH < 360 MPa , (1.3 ReH > 360 MPa < 420 MPa)</p> <p>1.0035, 1.0038, 1.0039, 1.0044, 1.0112, 1.0116, 1.0130, 1.0145, 1.0253, 1.0254, 1.0255, 1.0258, 1.0259, 1.0319, 1.0345, 1.0345, 1.0345, 1.0348, 1.0352, 1.0418, 1.0420, 1.0425, 1.0425, 1.0425, 1.0451, 1.0452, 1.0453, 1.0457, 1.0459, 1.0460, 1.0460, 1.0461, 1.0486, 1.0490, 1.0491, 1.0619, 1.1100, 1.0409, 1.0421, 1.0426, 1.0429, 1.0430, 1.0436, 1.0473, 1.0481, 1.0482, 1.0484, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, 1.8902, 1.8912, 1.8932 S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, L415NB, L415MB, WStE 380, WStE 420, S420NL 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, 70; A 633, Gr. A, C; A 711 Gr. 1013; API 5 L Gr. B, X42, X52, X60</p>																				
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WELDING POSITIONS																					
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>V</th> <th>Fe</th> </tr> </thead> <tbody> <tr> <td>0.08</td> <td>0.4</td> <td>0.6</td> <td>0.02</td> <td>0.02</td> <td>0.04</td> <td>0.05</td> <td>0.02</td> <td>0.015</td> <td>Rem.</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	Mo	V	Fe	0.08	0.4	0.6	0.02	0.02	0.04	0.05	0.02	0.015	Rem.
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ALL WELD MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th>Heat Treatment</th> <th>R_{p0,2} MPa</th> <th>R_m MPa</th> <th>A₅ (%)</th> <th>Impact Energy (J) ISO-V 0°C</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>450</td> <td>570</td> <td>25</td> <td>66</td> </tr> </tbody> </table>	Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V 0°C	As Welded /	450	570	25	66										
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As Welded /	450	570	25	66																	
REDRYING TEMPERATURE	140°C / 2 hr																				
GAS ACCORDING EN 14175																					



CEWELD E 6013 T

E 6013 T 1,6 X 250MM

Type	KG/unit	EANCode
Can	2,0	8720663400628

E 6013 T 2,0 X 300MM

Type	KG/unit	EANCode
Vacuum	1,8	8720682050583

E 6013 T 2,5 X 350MM

Type	KG/unit	EANCode
Vacuum	2,0	8720682050590

E 6013 T 3,2 X 450MM

Type	KG/unit	EANCode
Vacuum	2,8	8720682050606

E 6013 T 4,0 X 450MM

Type	KG/unit	EANCode
Vacuum	3,0	8720682050613

E 6013 T 5,0 X 450MM

Type	KG/unit	EANCode
Vacuum	2,3	8720682050620