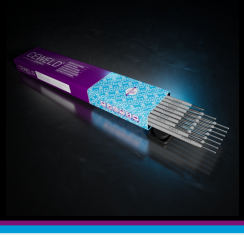


CEWELD E 6013 S

certilas® THE FILLER METAL SPECIALIST

TYPE

Rutile E 6013 welding electrode for stick SMAW welding of mild steels.(E6013, E 38 0)

APPLICATIONS

CEWELD® E 6013 S is a medium thick coated electrode for all kinds of steel structures and is particularly suited for welding jobs at poorly accessible points and badly prepared seams. Shipbuilding, general construction, vessels, wagons, repair welding, pipe welding

PROPERTIES

CEWELD® E 6013 S can be welded in all positions, with the exception of the PG position, which is only possible depending on the diameter. It shows good gap bridging and easy slag removal with a very stable arc.
In most cases, it is insensitive to scale, primer and zinc.

CLASSIFICATION

AWS	A 5.1: E 6013
EN ISO	2560-A: E 38 0 R 12
F-nr	2
FM	1

SUITABLE FOR

Rp< 380 MPa (52 ksi) ISO 15608: 1.1 ReH < 275 MPa**, 1.2** 275 < ReH < 360 MPa **, (1.3** ReH > 360 MPa < 380MPa**)**
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,
S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB,
A, B, D, E, A 32-E 36
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

APPROVALS

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S
0.08	0.4	0.5	0.02	0.02

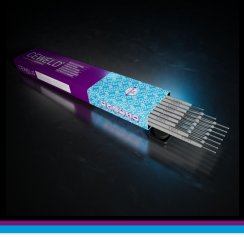
ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V 0°C
As Welded /	410	530	25	65

REDRYING TEMPERATURE

140°C / 1 hr

GAS ACCORDING EN 14175



CEWELD E 6013 S

certilas® THE FILLER METAL SPECIALIST

E 6013 S 2,0 X 300MM

Type	KG/unit	EANCode
Vacuum	2,0	8720682050545

E 6013 S 2,5 X 350MM

Type	KG/unit	EANCode
Vacuum	2,4	8720682050552

E 6013 S 3,2 X 350MM

Type	KG/unit	EANCode
Vacuum	2,3	8720682050262

E 6013 S 4,0 X 350MM

Type	KG/unit	EANCode
Vacuum	2,3	8720682050569

E 6013 S 5,0 X 450MM

Type	KG/unit	EANCode
Vacuum	3,0	8720682050576