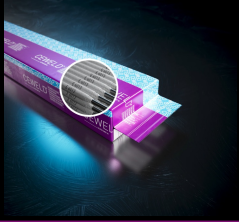


CEWELD E 6013 S

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, the PG position only to a limited extent as it depends 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 EN ISO F-nr FM	A 5.1: E 6013 2560-A: E 38 0 R 12 2 1			
SUITABLE FOR	Re ≤ 380 MPa (55 ksi) ISO 15608: 1.1(ReH < 275 MPa) 1.2 (275 < ReH < 360 MPa) 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, 1.0427, 1.0432, 1.0446, 1.0451, 1.0452, 1.0453, 1.0457, 1.0459, 1.0460, 1.0460, 1.0461, 1.0486, 1.0490, 1.0491, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, 1.1138, 1.5419, 1.8948 C 22.8 S1, S185, S235JRG2, S235JR S235JRH, S275JR, P235S, S235J2G3, P265S, S275J2, P235TR1, P235TR2, P265TR1, P265TR2, P235GH, P235GH, P235GH, P195GH, P245GH, L245ME, GE200, P265GH, P265GH, P265GH, C 22.3, C 21 , GE240, P215NL, P255QL, P265NL, L245NE, C 22.8, P250GH, P275N, S275N, S275NL, GP240GH, P275SL, 21 Mn 6, StE 320.7, St 52.0, P280GH, (X42ME) L290ME, P305GH, P355GH, P295GH, L290NE, S355N, S355NL, P355N, P355NL1, S355J2G3, G21Mn5, G20Mo5, X52QE, ASTM: A 27 u. A36 Gr. all; A214; A 242 Gr.1-5; A266 Gr. 1, 2, 4; A283 Gr. A, B, C, D; A285 Gr. A, B, C; A299 Gr. A, B; A328; A366; A515 Gr. 60, 65, 70; A516 Gr. 55; A570 Gr. 30, 33, 36, 40, 45; A 572 Gr. 42, 50; A606 Gr. Alle; A607 Gr. 45; A656 Gr. 50, 60; A668 Gr. A, B; A907 Gr. 30, 33, 36, 40; A841; A851 Gr. 1, 2; A935 Gr.45; A936 Gr. 50; 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	R _m 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

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