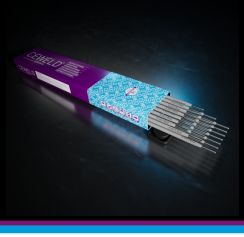


CEWELD E 6013 Root

certilas® THE FILLER METAL SPECIALIST

TYPE

Rutile basic electrode for SMAW welding. (Type E 38 2)

APPLICATIONS

CEWELD® E 6013 is a classic rutile- basic stick electrode preferably for welding in the weld root area.
Areas of application are: Shipbuilding, construction, buildings, pipe welding

PROPERTIES

CEWELD® E 6013 Root is a thick basic-rutile coated electrode for welding low alloyed steels with tensile strength up to 510 MPa. Recommended for root welding in pipelines due to excellent welding properties. The weld metal deposit has high mechanical properties and can be used for a wide range of materials.

CLASSIFICATION

AWS	A 5.1: E 6013
EN ISO	2560-A: E 38 2 RB 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
0.1	0.2	0.5	0.02	0.02

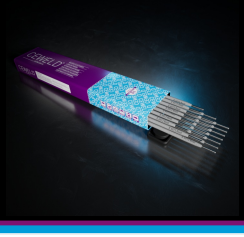
ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V -20°C	Impact Energy (J) ISO-V 0°C
As Welded /	400	500	25	50	65

REDRYING TEMPERATURE

140°C / 1 hr

GAS ACCORDING EN 14175



CEWELD E 6013 Root

E 6013 ROOT 2,5 X 300MM	Type	KG/unit	EANCode
	Can	2,6	8720663400277

E 6013 ROOT 3,2 X 350MM	Type	KG/unit	EANCode
	Can	2,6	8720663400284

E 6013 ROOT 4,0 X 450MM	Type	KG/unit	EANCode
	Can	3,3	8720663400291