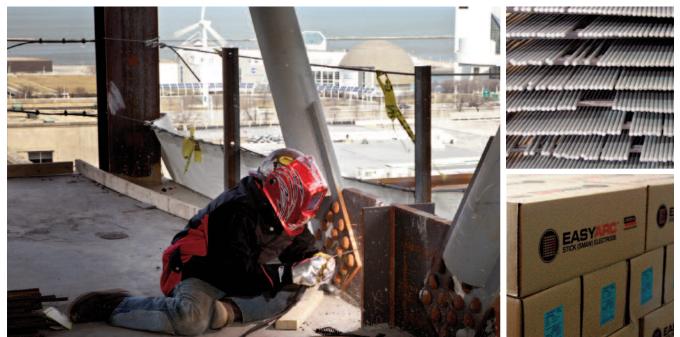
PT. LINCOLN ELECTRIC INDONESIA

MILD STEEL ELECTRODES

EASYARC ID 6013

AWS E6013



KEY FEATURES:

- All position operation. •
- Excellent restrike. ۲
- Smooth and stable arc even at low currents
- Smooth bead appearance

CONFORMANCES

- ABS: Class 2Y •
- Lloyds: 2M, 2YM
- BKI: Class 2Y
- GL Class 2 •

DIAMETERS / PACKAGING

Diameter (mm) Package (Kg) Pallet (Kg) Part Number Length (mm) 2.5 350 1900 20 IE60130C23 32 2000 IE60130C33 350 20 4.0 350 20 2000 IE60130C43 5.0 450 20 1600 IE60130C54 1800 3.2 400 20 IE60130C3N 1800 IE60130C4N 40 400 20 32 450 20 1600 IE60130C34 4.0 450 20 1600 IE60130C44



KEY APPLICATIONS:

- **General Fabrication** •
- Sheet Metal
- Irregular or short welds that change direction
- Shipbuilding

WELDING POSITIONS

All

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MECHANICAL PROPERTIES

	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Charpy V-Notch J @ 0°C	
Requirements - AWS A5.1 E6013	430 min	330 min	22 min.	NS	
Typical Values - As Welded	480	430	24	60	

DEPOSIT COMPOSITION

	%C	%Mn	%Si	%P	%S
Requirements - AWS AWS A5.1 E6013	0.20 max	1.20 max	1.0 max	NS	NS
Typical Values - As Welded	0.09	0.46	0.30	0.022	0.015

TYPICAL OPERATING PROCEDURES

	2.5mm	3.2mm	4.0mm	5.0mm	
	Current (Amps)	Current (Amps)	Current (Amps)	Current (Amps)	
AC	85 - 105	90 - 130	130 - 160	155 - 195	
DC+-	65 -95	85 - 110	125 - 155	145 - 170	

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

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