

EASYARC ID 6013

AWS E6013

**KEY FEATURES:**

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

KEY APPLICATIONS:

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

CONFORMANCES

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

WELDING POSITIONS

All

DIAMETERS / PACKAGING

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

MECHANICAL PROPERTIES

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

DEPOSIT COMPOSITION

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

TYPICAL OPERATING PROCEDURES

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