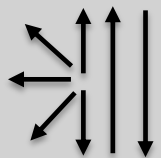


Classification							
AWS A5.1		AWS A5.1M		EN ISO 2560-A		EN ISO 2560-B	
E6013		E4313		E 38 0 RC 11		E 43 13 A	
Characteristics and typical fields of application							
Rutile-cellulosic electrode with good weldability in all positions including vertical-down. Most popular E6013 type, suitable for small transformers with low OCV. Very good operating characteristics. The Slag Covering and its removability are good. Flexible coating, good for tack welding. Versatile applications in structural welding, automotive fabrication, boiler and tank welding, and in shipbuilding. Also suitable for galvanized components.							
Base Materials							
Steels up to a yield strength of 380 N/mm ² (52 ksi) S275JR, S235J0G3 - S355J0G3, P235GH, P265GH, P255NH, P235T1, P355T1, P235T2-P355T2, P235G1TH, P255G1TH, L210 - L360NB, L290MB, S235JRS1 - S235J0S1, S235JRS2 - S235J0S2 ASTM A36 a. A53 Gr. all; A106 Gr. A, B, C A 135 Gr. A, B; A283 Gr. A, B, C, D; A366; A285 Gr. A, B, C; A500 Gr. A, B, C; A570 Gr. 30, 33, 36, 40, 45; A607 Gr. 45; A668 Gr. A, B; A907 Gr. 30, 33, 36, 40; A935 Gr.45; A936 Gr. 50; API 5 L Gr. B, X42 - X52							
Typical analysis of all weld metal (wt.-%)							
C		Si		Mn			
0.08		0.40		0.45			
Mechanical properties of all-weld metal							
Heat treatment	Yield strength R _e N/mm ²	Tensile strength R _m N/mm ²	Elongation (L ₀ =5d ₀)	Impact work ISO-V KV J			
	MPa	MPa	%	+ 20 °C	- 0 °C		
As Welded	477	550	20	55	50		
Operating data							
		Polarity AC / DCEN / DCEP		Re-drying not necessary Electrode Identification : Bohler Fox S OHV / E6013			
Approvals							
ABS, BKI							
Size, Packaging and Electrical Operating Data							
Size mm		Carton Box		Amperage (A)			
∅	Length	Kg / Pack	Kg / Box				
2.50	350	5.0	20.0	60-100			
3.25	350 / 450	5.0	20.0	90-130			
4.00	350 / 450	5.0	20.0	110-170			
5.00	450	5.0	20.0	170-240			