Lincoln® 6013

TOP FEATURES

- Suitable for welding on thin sheets.
- Smooth welds, self-releasing slag and good gap-bridging
- Very good weldability on AC and DC+ current.

CLASSIFICATION

AWS A5.1	E6013
EN ISO 2560-A	E 38 A R 11

CURRENT TYPE

AC, DC-, DC+

WELDING POSITIONS

All positions

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S
0.09	0.5	0.4	≤0.03	≤0.03

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) +20°C
AWS A5.1	AW	≥330	≥430	≥17	not specified
EN ISO 2560-A	AW	≥380	470-600	≥20	not specified
Typical values	AW	470	560	22	65

AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.0 x 300	50-70
2.5 x 350	60-85
3.2 x 350	100-125
4.0 x 350	130-170

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.0 x 300	CBOH	176	1.9	L60132030CBOH
2.5 x 350	CBOH	145	2.7	L60132535CBOH
	CBOX	240	4.5	L60132535CBOX
3.2 x 350	CBOH	95	2.8	L60133235CBOH
	CBOX	108	4.7	L60134035CBOX
4.0 x 350	CBOH	65	2.8	L60134035CBOH
	CBOX	159	4.7	L60133235CBOX

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

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.