

Arcweld 6013

TOP FEATURES

- Stable arc and low spatter level.
- Good slag releasing.
- Nice bead appearance.
- Very good weldability on DC - current and AC
- Can also be used in DC+.

CLASSIFICATION

AWS A5.1	E 6013
EN ISO 2560-A	E 38 0 R 12

CURRENT TYPE

DC- / AC (OCV min. 60V)

WELDING POSITIONS

All position, except vertical down

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

C	Mn	Si	P	S
0.09	0.4	0.3	≤0.03	≤0.02

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Required	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) 0°C
AWS A5.1	AW	≥330	≥430	≥17	not specified
EN ISO 2560-A	AW	not specified	470-600	≥20	min. 47
Typical values	AW	430	550	24	55

*AW: As-welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5x350	60-90
3.2x350	110-135
4.0x350	160-180

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	CBOX	238	4.5	609010-1
3.2 x 350	CBOX	140	4.5	609011-1
4.0 x 350	CBOX	90	4.5	609012-1

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.

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