

Line 13

TOP FEATURES

- Medium-coated rutile stick electrode, suitable for all positional welding, except vertically down
- Operates on low open circuit voltage
- Efficiency 100%
- Excellent choice when welding on primed or dirty plates

CLASSIFICATION

AWS A5.1 E6013
EN ISO 2560-A E 42 0 R 12

CURRENT TYPE

AC, DC-

WELDING POSITIONS

All position, except vertical down

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

C	Mn	Si	P	S
0.09	0.55	0.40	0.030	0.020

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Required	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) 0°C
EN ISO 2560-A	AW	≥420	500-640	≥24	≥47

* AW: As-welded

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	CBOX	215	3.8	W000384577
3.2 x 450	CBOX	130	5.7	W000384578

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.