Sureweld 6013



Sureweld 6013 is an all-position electrode. The arc is very stable even when low-voltage open circuit transformers are used. The power of its arc allows depositing quick welds, medium penetration, and good appearance. Sureweld 6013 minimizes the risk of trapping the slag due to its special characteristics and mineral coating. Sureweld 6013 is used on a wide array of mild steel fabrication where ease of operation and good appearance is required. Sureweld 6013 is recommended for welding vehicle bodies, profiles, tanks, ducts chassis, freight cars, ornamental jobs and thin-sheet structures.

Classifications	AWS A5.1 : E6013
Approvals	CWB CSA W48 E4913
Industry	Industrial and General Fabrication Mobile Equipment Ship/Barge Building

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC+, DC- or AC
Coating Type	High titania

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Reduction in Area	Elongation
As Welded	482 MPa (70 ksi)	558 MPa (81 ksi)	55 %	27 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	0 °C (32 °F)	47 J (35 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si
0.10	0.60	0.50

Deposition Data

Diameter	Current	Deposition Rate	Deposition Efficiency %
3.2 mm (1/8 in.)	120-135 A	1 kg/h (2.1 lb/h)	73 %
2.4 mm (3/32 in.)	60-90 A	0.7 kg/h (1.6 lb/h)	73 %
4.0 mm (5/32 in.)	145-190 A	1.2 kg/h (2.6 lb/h)	75 %
4.0 mm (5/32 in.)	145-190 A	1.45 kg/h (3 lb/h)	74 %

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