


Technical data sheet <small>011121MBA</small>	Coated SMAW Electrode WA SPEEDARC 6013-E	
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CLASSIFICATION

ASME IIC SFA-5.1 / AWS A5.1: E6013
EN ISO 2560-A: E 42 0 RC 11

DESCRIPTION

- Rutile coated SMAW electrode designed for all-position welding
- Easily detachable slag
- Very good bead appearance, with concave fillet free of undercut
- Easy handling in all positions, including vertical downwards
- Instantaneous striking and re-striking

APPLICATIONS

Construction steels for general use, Tube steels, Ship steels, Steels for Boiler and Pressure Vessels, High strength steels, Heat resisting steels, Cold tough steels

Examples

Unalloyed construction steels	EN 10025	S235JRG1 to S355J2G3
Boiler plate	EN 10028-2	P235GH to P355GH
Fine-grained steels	EN 10028-3	P275N to P420N, P275NL to P420NL
	EN 10113	S275N to S420N, S275NL to S420NL
Pipe steels	EN 10208	L240NB to L415NB
	API 5L	X42, X46, X52, X60
Pressure vessel plates	ASTM SA516	Gr55 to Gr70
Shipbuilding steels	A, E, A32-F40	
Cast steels	DIN 1681	GS-38, GS-45, GS-52
IS/TR 15608: Groups 1.1, 1.2, 1.3, 2.1 and 3.1		

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Mn	Si
0.07	0.5	0.35

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
470	420	20	0°C: 47

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
520	460	24	-10°C: 50

OPERATING CONDITIONS

Electrode Ø x L [mm]	2.5 x 350	3.2 x 350	4.0 x 350
Current [A]	60 - 90	90 - 130	125 - 180
= +	~ 40V		

WELDING POSITIONS

EN ISO 6947: PA, PB, PC, PF, PE
ASME IX: 1G, 2F, 2G, 3G, 4G

PACKAGING

Electrode Ø x L [mm]	2.5 x 350	3.2 x 350	4.0 x 350
Weight/box [kg]	5	5	5

Other packaging and other sizes: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.