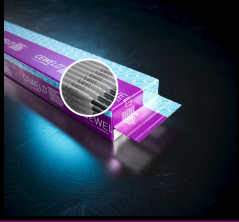


CEWELD E 6013 T

TYPE	Thick coated rutile electrode for SMAW welding. (Type E 42 0)									
APPLICATIONS	CEWELD® E 6013 T is a thick coated electrode for joining and surfacing steel structures of all kinds in mechanical engineering, body and wagon building, fabrication of vessels and containers and in shipbuilding.									
PROPERTIES	CEWELD® E 6013 T is eminently weldable and possesses excellent welding properties in all positions except vertically down. Easy strike, no spatter losses. Very easy slag removal. Smooth, finely rippled seam surface and low fume.									
CLASSIFICATION	AWS	A 5.1: E 6013								
	EN ISO	2560-A: E 42 0 RR 12								
	F-nr	2								
	FM	1								
SUITABLE FOR	Rp< 420 MPa (60ksi) ISO 15608: 1.1(ReH < 275 MPa), 1.2 (275 < ReH < 360 MPa), 1.3 (ReH > 360 MPa < 420 MPa) 1.0035, 1.0038, 1.0039, 1.0044, 1.0112, 1.0116, 1.0130, 1.0145, 1.0253, 1.0254, 1.0255, 1.0258, 1.0259, 1.0319, 1.0345, 1.0345, 1.0345, 1.0348, 1.0352, 1.0418, 1.0420, 1.0425, 1.0425, 1.0425, 1.0451, 1.0452, 1.0453, 1.0457, 1.0459, 1.0460, 1.0460, 1.0461, 1.0486, 1.0490, 1.0491, 1.0619, 1.1100, 1.0409, 1.0421, 1.0426, 1.0429, 1.0430, 1.0436, 1.0473, 1.0481, 1.0482, 1.0484, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, 1.8902, 1.8912, 1.8932 S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, L415NB, L415MB, WStE 380, WStE 420, S420NL A, B, D ASTM A 106, Gr. A, B; A 283 Gr. A, C; A 285 Gr. A, B, C; A 501, Gr. B; A 573, Gr. 58, 65, 70; A 633, Gr. A, C; A 711 Gr. 1013; API 5 L Gr. B, X42, X52, X60									
APPROVALS	CE									
WELDING POSITIONS										
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Ni	Mo	V	Fe
	0.08	0.4	0.6	0.02	0.02	0.04	0.05	0.02	0.015	Rem.
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V				Hardness	
					0°C					
	As Welded	450	570	25	66				HRc	
REDRYING	140°C / 2 hr									
GAS ACC. EN ISO 14175										



CEWELD E 6013 T

E 6013 T 1,6 X 250MM

Packaging	KG/unit	EanCode
Can	2,0	8720663400628

E 6013 T 2,0 X 300MM

Packaging	KG/unit	EanCode
Vacuum	1,8	8720682050583

E 6013 T 2,5 X 350MM

Packaging	KG/unit	EanCode
Vacuum	2,0	8720682050590

E 6013 T 3,2 X 450MM

Packaging	KG/unit	EanCode
Vacuum	2,8	8720682050606

E 6013 T 4,0 X 450MM

Packaging	KG/unit	EanCode
Vacuum	3,0	8720682050613

E 6013 T 5,0 X 450MM

Packaging	KG/unit	EanCode
Vacuum	2,3	8720682050620