



# CEWELD E 6013 Fall

**TYPE** Rutile cellulosic electrode for welding in all positions. (Type E 42 0)

**APPLICATIONS** CEWELD® E 6013 Fall was specially developed for maintenance and repair work in shipbuilding and ship repair as well as for similar work on poorly prepared seams in structural engineering.

**PROPERTIES** CEWELD® 6013 drop has excellent ignition and re-ignition properties and can be easily welded with small transformers (42 V). The slag solidifies surprisingly quickly, which is why it is used particularly in a vertical downward position with high speed and deep penetration.

**CLASSIFICATION**

AWS	A 5.1: E 6013
EN ISO	2560-A: E 42 0 RC 11
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 THE FILLER METAL (%)**

C	Si	Mn	P	S
0.08	0.4	0.6	0.02	0.02

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V	
				0°C	Hardness
As Welded	450	560	22	67	HRC

**REDRYING** 140°C / 1 hr

**CURRENT TYPE:** AC, DC+/-

**GAS ACC. EN ISO 14175**



# CEWELD E 6013 Fall

E 6013 FALL 2,0 X 300MM	Packaging	KG/unit	EanCode
	Can	2,4	8720663400208
E 6013 FALL 2,5 X 350MM	Packaging	KG/unit	EanCode
	Vacuum	2,0	8720682050507
E 6013 FALL 3,2 X 350MM	Packaging	KG/unit	EanCode
	Vacuum	2,1	8720682050514
E 6013 FALL 4,0 X 350MM	Packaging	KG/unit	EanCode
	Vacuum	2,2	8720682050521
E 6013 FALL 5,0 X 350MM	Packaging	KG/unit	EanCode
	Vacuum	,2,	8720682050538