



# CEWELD E 6013 S

**TYPE** Rutile E 6013 welding electrode for stick SMAW welding of mild steels.(E6013, E 38 0)

**APPLICATIONS** CEWELD® E 6013 S is a medium thick coated electrode for all kinds of steel structures and is particularly suited for welding jobs at poorly accessible points and badly prepared seams. Shipbuilding, general construction, vessels, wagons, repair welding, pipe welding

**PROPERTIES** CEWELD® E 6013 S can be welded in all positions, with the exception of the PG position, which is only possible depending on the diameter. It shows good gap bridging and easy slag removal with a very stable arc. In most cases, it is insensitive to scale, primer and zinc.

**CLASSIFICATION**

AWS	A 5.1: E 6013
EN ISO	2560-A: E 38 0 R 12
F-nr	2
FM	1

**SUITABLE FOR** **Rp < 380 MPa (52 ksi) ISO 15608: 1.1** ReH < 275 MPa, 1.2 275 < ReH < 360 MPa , (1.3 ReH > 360 MPa < 380MPa)

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, S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, A, B, D, E, A 32-E 36  
 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; A 633, Gr. A, C; A 711 Gr. 1013;  
 API 5 L Gr. B, X42, X52

**APPROVALS** CE

**WELDING POSITIONS**

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S
	0.08	0.4	0.5	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	Hardness
					0°C	
	As Welded	410	530	25	65	HRc

**REDRYING** 140°C / 1 hr

**GAS ACC.** EN ISO 14175



# CEWELD E 6013 S

E 6013 S 2,0 X 300MM

Packaging	KG/unit	EanCode
Vacuum	2,0	8720682050545

E 6013 S 2,5 X 350MM

Packaging	KG/unit	EanCode
Vacuum	2,4	8720682050552

E 6013 S 3,2 X 350MM

Packaging	KG/unit	EanCode
Vacuum	2,3	8720682050262

E 6013 S 4,0 X 350MM

Packaging	KG/unit	EanCode
Vacuum	2,3	8720682050569

E 6013 S 5,0 X 450MM

Packaging	KG/unit	EanCode
Vacuum	3,0	8720682050576