
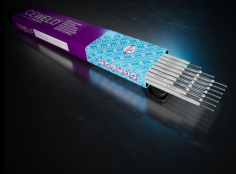




CEWELD E 6013 T

TYPE	Electrode rutile 6013 à enrobage épais pour le soudage SMAW																				
APPLICATIONS	Construction de yachts, de wagons, de trains, de navires, de bateaux, constructions générales																				
PROPRIÉTÉS	CEWELD® E 6013 T est une électrode à enrobage épais destinée à l'assemblage et au surfacage de structures en acier de toutes sortes dans la construction mécanique, la construction de carrosseries et de wagons, la fabrication de navires et de conteneurs et la construction navale. La CEWELD® E 6013 T est éminemment soudable et possède d'excellentes propriétés de soudage dans toutes les positions, sauf verticalement vers le bas. Frappe facile, pas de pertes de projections. Élimination très facile du laitier. Surface de soudure lisse, finement ondulée et peu de fumées.																				
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.1: E 6013</td> </tr> <tr> <td>EN ISO</td> <td>2560-A: E 42 0 RR 12</td> </tr> <tr> <td>F-nr</td> <td>2</td> </tr> <tr> <td>FM</td> <td>1</td> </tr> </table>	AWS	A 5.1: E 6013	EN ISO	2560-A: E 42 0 RR 12	F-nr	2	FM	1												
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EN ISO	2560-A: E 42 0 RR 12																				
F-nr	2																				
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CONVIENT POUR	<p>Rp < 420 MPa (60ksi) ISO 15608: 1.1 ReH < 275 MPa, 1.2 275 < ReH < 360 MPa, (1.3 ReH > 360 MPa < 420 MPa)</p> <p>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</p> <p>A, B, D</p> <p>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</p>																				
AGRÉMENTS	CE																				
POSITIONS DE SOUDAGE																					
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>V</th> <th>Fe</th> </tr> </thead> <tbody> <tr> <td>0.08</td> <td>0.4</td> <td>0.6</td> <td>0.02</td> <td>0.02</td> <td>0.04</td> <td>0.05</td> <td>0.02</td> <td>0.015</td> <td>Rem.</td> </tr> </tbody> </table>	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.
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		0°C																			
As Welded	450	570	25	66		HRc															
ETUVAGE	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