

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

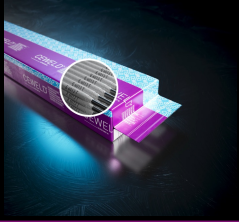


TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Ni	Mo	V	Fe
	0.08	0.4	0.6	0.02	0.02	0.04	0.05	0.02	0.015	Rem.

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