



6013



DESCRIPTION: 6013 is a high titanic coated electrode. This electrode was primarily designed to provide good wetting and shallow penetration for thin sheet metal applications (using smaller diameter electrodes), but with sufficient penetration for welding medium gauge steel. As a result, 6013 is an all-purpose electrode that provides a soft steady arc which is easily regenerated, easy slag control for vertical-down welding, low spatter and a beautiful bead appearance. 6013 electrodes may be used in any position with AC or DC (straight or reverse polarity).

APPROVALS: Meets AWS A5.1 Class E6013.

APPLICATIONS: 6013 electrode is commonly used for automobile bodies, truck frames and bodies, ornamental iron, metal furniture, farm implementations, machinery guards, storage tanks, or wherever appearance is important or desirable.

CHEMICAL COMPOSITION

Carbon	.08
Manganese	.45
Silicon	.18
Phosphorus	.012
Sulfur	.009

MECHANICAL PROPERTIES

Tensile Strength	
68,200 PSI	470 MPA
Yield Strength	
59,500 PSI	410 MPA
Elongation	28%

Sizes and recommended current range (DC<±>)

Diameter (mm)	2.6	3.2	4.0	5.0
Length (mm)	350	350	450	450
Amps (F)	60-90	100-120	110-160	160-220
(V&OH)	50-80	80-110	100-150	140-200