

EN ISO 2560-A: E 42 0 RC 1 1
 EN ISO 2560-B: E4312 A
 AWS A5.1: E6013
 AWS A5.1M: E4313

BÖHLER AWS E6013

SMAW rutile-cellulosic electrode, unalloyed

Description

Rutile-cellulosic electrode with good weldability in all positions including vertical down. Excellent gap-bridging and arc-striking ability. For tack welding and load fit ups. General purpose for industry and trade, assembly and shop welding

Typical Composition of All-weld Metal

	C	Si	Mn
Wt-%	0.08	0.4	0.5

Mechanical Properties of All-weld Metal

Yield strength R_e MPa:	440	(≥ 420)
Tensile strength R_m MPa:	540	(500-640)
Elongation A ($L_0=5d_0$) %:	22	(≥ 20)
Impact work ISO-V KV J	+20 C: 80	
	0 C: 55	(≥ 47)

u untreated, as welded

Operating Data



	\emptyset mm	L mm	Current A
Redrying: not necessary	2.0	300	40-60
Electrode marking: BÖHLER AWS E6013 E 42 0 RC 1 1	2.5	350	60-100
	3.2	350	90-140
	4.0	350	150-190
	5.0	450	190-240



Base Materials

Steels up to a yield strength of 380 MPa (52 ksi)

S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, shipbuilding steels: 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; A 633 Gr. A, C; A 711 Gr. 1013

API 5 L Gr. B, X42, X52

Approvals and Certificates

TÜV-D (in process), ABS (in process), DNV (in process), LR (in process), CE (in process)