

Phoenix 6013

Covered electrode

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|------------------------|---------------|------------------|
| Classifications | EN 499 | AWS A 5.1 |
| | E 42 0 RC 11 | E6013 |

Characteristics and field of use Rutile cellulose covered electrode.
General purpose; useable in all positions; excellent gap-bridging and arc-striking ability; for tack-welding and bad fit-ups; excellent vertical down characteristics.

Materials S235JRG2 - S355J2, GS-38, GS-45; P265 boiler steels P235GH, P265GH, P295GH; shipbuilding steels corresp. to app.-grade 2; fine grained structural steels up to P355N; weldable reinforcing steel bars

| | | | |
|------------------------------|----------|-----------|-----------|
| Typical analysis in % | C | Si | Mn |
| | 0.09 | 0.35 | 0.50 |

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|--|----------------|--|---------------------------------------|---|------------------------------|
| Mechanical properties of the weld metal according to EN 1597-1 (min. values at RT) | Heat-treatment | Yield strength 0.2 % N/mm ² | Tensile strength N/mm ² | Elongation (L ₀ =5d ₀) % | Impact values in J CVN |
| | AW | 420 | 510 | 22 | 50 |

Welding position



Polarity = - / ~

Approvals

ABS (Grade 2)
LR (Grade 2/2Y)
DNV (Grade 2)

| | | | | |
|---|------------------------|------------------|----------------|-------------------|
| Packaging, weights and amperages | Dimensions (mm) | pcs./pack | kg/pack | Amperage A |
| | 2.5 x 350 | 279 | 5.0 | 70-110 |
| | 3.2 x 350 | 173 | 5.0 | 110-160 |
| | 4.0 x 350 | 113 | 5.0 | 140-200 |
| | 5.0 x 450 | 80 | 6.9 | 170-280 |