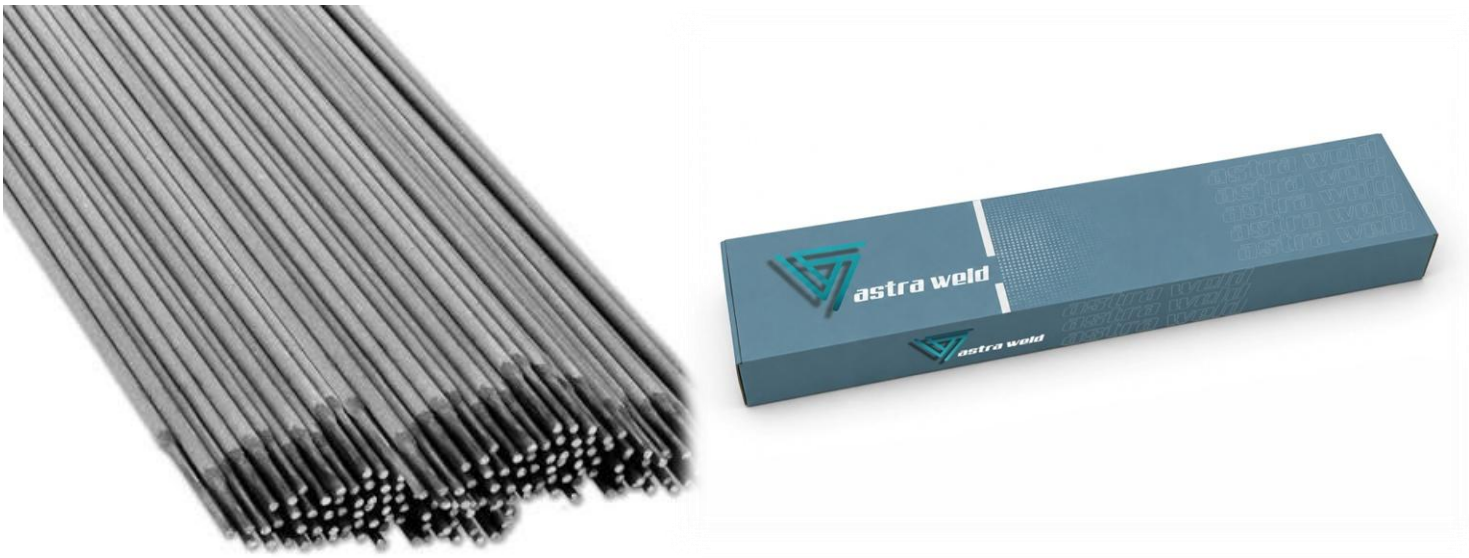




ASTRA E6013

Standards

TS EN ISO 2560-A

AWS/ASME SFA-5.1

Classifications

E 42 0 RR 1 2

E 6013

Features and Applications :

E 6013 is rutile-based carbon steel electrode, It has very good welding usability that enables it to perform all-position welding, operates on AC/DC, removal of slag is easy, has stable arc and also has very good bead appearance. It is easy to operate, which makes re-striking the arc easy.

It is suitable for welding structures made of low carbon steel, performs very well in welding thin and small size steel plates and also has very good performance in the situation that requires nice and clean bead appearance.

Dimensions and Weights :

Ø 2,0 mm - 2,50 mm - 3,25 mm - 4,00 mm - 5,00 mm / 1kg - 5kg - 6.5 kg

Chemical Composition :

Item	C	Mn	Si	S	P	Ni	Cr	Mo	V
Standard	≤0.20	≤1.20	≤1.00	≤0.035	≤0.040	≤0.30	≤0.20	≤0.30	≤0.08
Item	0.079	0.38	0.21	0.018	0.024	0.020	0.032	0.005	0.010

Mechanical Properties of Deposited Metal :

Test Item	Rm (N/mm ²)	Rel (N/mm ²)	A(%)	KV2(J) 0℃
Standard	≥430	≥330	≥16	≥47
Item	485	380	28.5	86

Reference Current (DC) :

Diameter	2.0	2.5	3.2	4.0	5.0
Amperage	40~70	50~90	90~130	130~210	170~230

Welding Positions :

