

Sureweld 6013

Sureweld 6013 is an all-position electrode. The arc is very stable even when low-voltage open circuit transformers are used. The power of its arc allows depositing quick welds, medium penetration, and good appearance. Sureweld 6013 minimizes the risk of trapping the slag due to its special characteristics and mineral coating. Sureweld 6013 is used on a wide array of mild steel fabrication where ease of operation and good appearance is required. Sureweld 6013 is recommended for welding vehicle bodies, profiles, tanks, ducts chassis, freight cars, ornamental jobs and thin-sheet structures.

Specifications	
Classifications	ASME SFA 5.1 : E6013 AWS A5.1 : E6013
Approvals	CWB : CSA W48 E4913
Industry	Industrial and General Fabrication Mobile Equipment Ship/Barge Building

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC+-, AC
Alloy Type	Carbon Manganese

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
As Welded	458 MPa (66 ksi)	526 MPa (76 ksi)	27 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
As Welded	32 °C (90 °F)	47 J (35 ft-lb)
As Welded	-20 °C (-4 °F)	47 J (35 ft-lb)

Typical Weld Metal Analysis %		
C	Mn	Si
0.10	0.60	0.50

Deposition Data			
Diameter	Current	Deposition Efficiency (%)	Deposition Rate @ 90% I max
2.4 x 356.0 mm (3/32 x 14.0 in.)	60-90 A	73.0 %	0.73 kg/h (1.6 lbs/h)
3.2 x 356.0 mm (1/8 x 14.0 in.)	120-135 A	73.0 %	0.95 kg/h (2.1 lbs/h)
4.0 x 356.0 mm (5/32 x 14.0 in.)	145-190 A	71.2 %	1.59 kg/h (3.5 lbs/h)