

SUREWELD 6013

AWS A5.1: E6013

FEATURES

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 eliminates 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.

TYPICAL MECHANICAL PROPERTIES

| As Welded | |
|-------------------|-----------------|
| Yield Strength | 70 ksi, 482 MPa |
| Tensile Strength | 81 ksi, 558 MPa |
| Reduction in Area | 55% |
| Elongation in 2" | 27% |

CLASSIFICATIONS AND APPROVALS

- AWS A5.1: E6013
- ASME SFA 5.1

WELD METAL ANALYSIS

| | |
|----|--------|
| C | 0.095% |
| Mn | 0.32% |
| Si | 0.31% |
| P | 0.065% |
| S | 0.008% |

WELDING PROCESS

- SMAW (Stick)

INDUSTRIES

- General Fabrication
- Mobile Equipment
- Barges

SUREWELD 6013

 continued

DEPOSITION TABLE

| Diameter in (mm) | Optimal Current Amps | Current Range Amps | Deposition Rate lb/hr (kg/hr) | Efficiency % |
|------------------|----------------------|--------------------|-------------------------------|--------------|
| 3/32 (2.4) | 85 | 60 - 90 | 1.6 (0.7) | 73 |
| 1/8 (3.2) | 125 | 120 - 135 | 2.1 (1) | 73 |
| 5/32 (4.0) | 140 | 145 - 190 | 2.6 (1.2) | 75 |
| | 160 | 145 - 190 | 3 (1.45) | 74 |

PART NUMBER / PRODUCT INFORMATION

| Part Number | Description | UPC |
|-------------|------------------------|---------------|
| 812000149 | SW 6013 3/32X14X5#VALP | 662303202903 |
| 812000156 | SW 6013 1/8X14X5#VALP | 662303202910 |
| 812000164 | SW 6013 1/8X14X44#CTN | 662303202927 |
| 812000172 | SW 6013 5/32X14X5#VALP | 6662303202934 |