BÖHLER Q E 6013 RC

Stick electrode, unalloyed, rutile coated

Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.1 / SFA-5.1	AWS A5.1M
E 42 0 RC 1 1	E 4313 A	E6013	E4313

Characteristics and typical fields of application

Rutile-cellulosic electrode with good weld ability 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

Base materials

Steels up to a yield strength of 420 MPa S235JR-S355JR, S235J0-S355J0, 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

Typical analysis

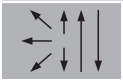
	C	Si	Mn
wt.-%	0.08	0.4	0.5

Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength R_e	Tensile strength R_m	Elongation A (L_0=5d_0)	Impact energy ISO-V KV J	
	MPa	MPa	%	20°C	±0°C
u	440 (≥ 420)	540 (≥ 500 – 640)	22 (≥ 20)	80	55 (≥ 47)

u untreated, as welded

Operating data



Polarity	DC – / AC
Electrode identification	Q E 6013 RC / 6013 / E 42 0 RC

Dimension mm	Current A
2.0 × 300	40 – 60
2.5 × 300	60 – 100
2.5 × 350	60 – 100
3.2 × 350	90 – 140
4.0 × 350	150 – 190
5.0 × 450	190 – 240

Approvals

TÜV (12677), DB (10.014.50), DNV, CE