

Mild Steel Stick Electrodes

DESCRIPTION

BLUME® E6013 is a mild steel stick electrode. Operable with low amperages on sheet metal. Excellent bead appearance.

CONFORMANCE
ASME SFA/AWS A5.1 E6013
WELDING POSITION

All Position

TYPICAL APPLICATION

BLUME® E6013 is used for welding of sheet metal and for irregular short welds that change position. Typically used for maintenance or repair welding. Can be used on small AC Welders with low open circuit voltage.

MECHANICAL PROPERTIES

	As-Welded with CO2
Yield Point, MPa	430
Tensile Strength, MPa	480
Elongation, % (L=4d)	22

CHARPY V-NOTCH IMPACT PROPERTIES

Testing Temp.	As-Welded with CO2 (J)
-20°F (-29°C)	72
-20°F (-29°C)	69
-20°F (-29°C)	68

UNDILUTED WELD METAL ANALYSIS (WT%)

	C	Mn	Si	S	P
As Welded	0.05	0.38	0.20	0.008	0.007
	Ni	Cr	Mo	-	-
As Welded	0.05	0.03	0.01	-	-



blume®

E6013

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SUGGESTED WELDING PARAMETERS

Ø x L	AC	DC+
3/32" x 12" (2.5mm x 300mm)	75 - 115	70 - 105
1/8" x 14" (3.2mm x 350mm)	110 - 140	100 - 135
5/32" x 16" (4.0mm x 400mm)	160 - 200	145 - 180

PACKAGING

Ø x L	Wt./Carton	Carton/Box	Net wt./Box
3/32" x 12" (2.5mm x 300mm)	5.5lbs (2.5kgs)	8	44 lbs (20 kgs)
1/8" x 14" (3.2mm x 350mm)	5.5lbs (2.5kgs)	8	44 lbs (20 kgs)
5/32" x 16" (4.0mm x 400mm)	5.5lbs (2.5kgs)	8	44 lbs (20 kgs)