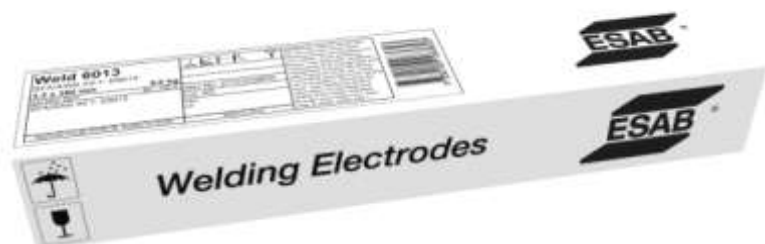




**Good slag detachability
Easy to strike
and restrike!**

ELECTRODE ESAB 6013



- Stable Arc even at low current
- deposits smooth weld beads in all position (except vertical down)
- same flux diameter all around the Electrode
- Less smoke
- 90% length of Electrode can be used
- exist in box of 2.5kg for 2.5mm
- pack of 20kg box for all dimension

REASON FOR ISSUE

EN classification added

GENERAL

General purpose, easy to use rutile electrode with good slag detachability. Suitable for all welding positions except vertical down.

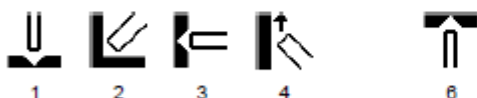
Min AC OCV: 50

Polarity: AC, DC+

Alloy Type: Carbon steel

Coating Type: Rutile

WELDING POSITIONS



CLASSIFICATIONS Electrode

SFA/AWS A5.1

E6013

EN ISO 2560-A

E 35 0 RA 12

APPROVALS

ABS

2

LR

2

ECONOMICS & CURRENT DATA

Dimension (mm) Ø x Length	Current (A)		W	η	N	B	H	T	U	Welding Positions
	Min	Max								
2.5 x 350	50	90	1.7	101	0.59	100	0.7	51	24	1,2,3,4,6
3.2 x 350	80	130	3.2	90	0.53	60	0.9	64	26	1,2,3,4,6
4.0 x 400	150	200	5.7	94	0.56	32	1.4	83	25	1,2,3,4,6

W = Weight (kg / 100 electrodes)

η = Efficiency (g weld metal x 100 / g core wire)

N = Effective value (kg weld metal / kg electrodes)

B = Changes (number of electrodes / kg weld metal)

H = Deposit rate at 90% of max current (kg weld metal / hour arc time)

T = Fusion time at 90% of max current (s / electrode)

U = Arc voltage (V)

Distributed by:

Les Gaz Industriels Ltd

Pailles Road – G.R.N.W. – P.O.Box 673 – Bell Village – Republic of Mauritius

Phone: +230 212 8306 – Fax: +230 212 0235

For technical information: contact your usual Sales Rep or our office