

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

