



# CEWELD E 6013 T

**TYPE** Thick coated rutile electrode for SMAW welding. ( Type E 42 0 )

**APPLICATIONS** CEWELD® E 6013 T is a thick-coated electrode for joining and applying steel structures of all kinds in mechanical engineering, car body and wagon construction, tank and container construction and shipbuilding.

**PROPERTIES** CEWELD® E 6013 T is a thick coated electrode for joining and surfacing steel structures of all kinds in mechanical engineering, body and wagon building, in the fabrication of vessels and containers, and in shipbuilding. The CEWELD® E 6013 T is eminently weldable and possesses excellent welding properties in all positions except vertically down. Easy strike, no spatter losses. Very easy slag removal. Smooth, finely rippled seam surface and low fume.

**CLASSIFICATION**

AWS	A 5.1: E 6013
EN ISO	2560-A: E 42 0 RR 12
F-nr	2
FM	1

**SUITABLE FOR** **Rp < 420 MPa (60ksi) ISO 15608: 1.1** ReH < 275 MPa, 1.2 275 < ReH < 360 MPa , (1.3 ReH > 360 MPa < 420 MPa)  
 1.0035, 1.0038, 1.0039, 1.0044, 1.0112, 1.0116, 1.0130, 1.0145, 1.0253, 1.0254, 1.0255, 1.0258, 1.0259, 1.0319, 1.0345, 1.0345, 1.0345, 1.0348, 1.0352, 1.0418, 1.0420, 1.0425, 1.0425, 1.0425, 1.0451, 1.0452, 1.0453, 1.0457, 1.0459, 1.0460, 1.0460, 1.0461, 1.0486, 1.0490, 1.0491, 1.0619, 1.1100, 1.0409, 1.0421, 1.0426, 1.0429, 1.0430, 1.0436, 1.0473, 1.0481, 1.0482, 1.0484, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, 1.8902, 1.8912, 1.8932  
 S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, L415NB, L415MB, WStE 380, WStE 420, S420NL  
 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, 70; A 633, Gr. A, C; A 711 Gr. 1013; API 5 L Gr. B, X42, X52, X60

**APPROVALS** CE

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

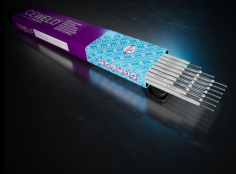
C	Si	Mn	P	S	Cr	Ni	Mo	V	Fe
0.08	0.4	0.6	0.02	0.02	0.04	0.05	0.02	0.015	Rem.

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				0°C		
As Welded	450	570	25	66		HRc

**REDRYING** 140°C / 2 hr

**GAS ACC. EN ISO 14175**



# CEWELD E 6013 T

E 6013 T 1,6 X 250MM

Packaging	KG/unit	EanCode
Can	2,0	8720663400628

E 6013 T 2,0 X 300MM

Packaging	KG/unit	EanCode
Vacuum	1,8	8720682050583

E 6013 T 2,5 X 350MM

Packaging	KG/unit	EanCode
Vacuum	2,0	8720682050590

E 6013 T 3,2 X 450MM

Packaging	KG/unit	EanCode
Vacuum	2,8	8720682050606

E 6013 T 4,0 X 450MM

Packaging	KG/unit	EanCode
Vacuum	3,0	8720682050613

E 6013 T 5,0 X 450MM

Packaging	KG/unit	EanCode
Vacuum	2,3	8720682050620