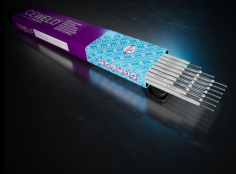




CEWELD E 6013 T

TYPE	Dik beklede rutiel elektrode voor het lassen van on- en laaggelegeerd staal																				
TOEPASSINGEN	Scheepsbouw, trailerbouw, constructiewerkzaamheden, montage en reparatie laswerk.																				
EIGENSCHAPPEN	CEWELD® E 6013 T is een dik beklede elektrode voor het verbinden van allerlei soorten staalconstructies in de machinebouw, carrosserie- en wagenbouw, bij de fabricage van schepen en containers in de scheepsbouw. De CEWELD® E 6013 T heeft uitstekende laseigenschappen in alle posities behalve verticaal neergaand. Ontsteekt gemakkelijk en geen spatverlies. Zeer gemakkelijke slakverwijdering. Glad, fijn lasnaadoppervlak en weinig rook.																				
CLASSIFICATIE	<table border="0"> <tr> <td>AWS</td> <td>A 5.1: E 6013</td> </tr> <tr> <td>EN ISO</td> <td>2560-A: E 42 0 RR 12</td> </tr> <tr> <td>F-nr</td> <td>2</td> </tr> <tr> <td>FM</td> <td>1</td> </tr> </table>	AWS	A 5.1: E 6013	EN ISO	2560-A: E 42 0 RR 12	F-nr	2	FM	1												
AWS	A 5.1: E 6013																				
EN ISO	2560-A: E 42 0 RR 12																				
F-nr	2																				
FM	1																				
GESCHIKT VOOR	<p>Rp < 420 MPa (60ksi) ISO 15608: 1.1 ReH < 275 MPa, 1.2 275 < ReH < 360 MPa, (1.3 ReH > 360 MPa < 420 MPa)</p> <p>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</p> <p>S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, L415NB, L415MB, WStE 380, WStE 420, S420NL</p> <p>A, B, D</p> <p>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</p>																				
GOEDKEURINGEN	CE																				
LASPOSITIES																					
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>V</th> <th>Fe</th> </tr> </thead> <tbody> <tr> <td>0.08</td> <td>0.4</td> <td>0.6</td> <td>0.02</td> <td>0.02</td> <td>0.04</td> <td>0.05</td> <td>0.02</td> <td>0.015</td> <td>Rem.</td> </tr> </tbody> </table>	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.
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.												
MECHANISCHE WAARDEN	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{p0,2} (MPa)</th> <th rowspan="2">R_m (MPa)</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th colspan="2">0°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>450</td> <td>570</td> <td>25</td> <td colspan="2">66</td> <td>HRc</td> </tr> </tbody> </table>	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness	0°C		As Welded	450	570	25	66		HRc				
Heat Treatment	R _{p0,2} (MPa)					R _m (MPa)	A ₅ (%)		Impact Energy (J) ISO-V		Hardness										
		0°C																			
As Welded	450	570	25	66		HRc															
HERDROGEN	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