

Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.1 / SFA-5.1	AWS A5.1M
E 42 0 RR 1 2	E 4313 A	E6013	E4313

Characteristics and typical fields of application

Rutile coated electrode. Minimum spatter formation, self-releasing slag; finely rippled, smooth welds with notch-free weld metal / parent metal interface. Easy welding of general-purpose structural steels; also suitable for vertical down welding in diam. up to 2.0 mm. Outstanding striking and re-striking ability. For use on small transformers (42 V, open circuit).

Base materials

S235JRG2 - S355J2; boiler steels P235GH, P265GH, P295GH; ship building steels; fine grained steels up to P355N and M-grades. ASTM A36 and A53 Gr. all; A106 Gr. A, B, C; A135 Gr. A, B; A283 Gr. A, B, C, D; A366; A285 Gr. A, B, C; A500 Gr. A, B, C; A570 Gr. 30, 33, 36, 40, 45; A607 Gr. 45; A668 Gr. A, B; A907 Gr. 30, 33, 36, 40; A935 Gr. 45; A936 Gr. 50; API 5 L Gr. B, X42 - X56

Typical analysis

	C	Si	Mn
wt.-%	0.08	0.35	0.55

Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength $R_{p0.2}$	Yield strength R_e	Elongation A ($L_0=5d_0$)	Impact energy ISO-V KV J
	MPa		%	20 °C
u	420	510	22	60

u untreated, as welded

Operating data

	Polarity	DC (-) / AC	Dimension mm	Current A
	Electrode identification	Q E 6013 RT / 6013 / E 42 0 RR	2.0 × 300	45 - 65
			2.5 × 350	60 - 100
			3.2 × 350	85 - 140
			4.0 × 350	130 - 200

Approvals

TÜV (12914.), DB (10.014.101), DNV, CE
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