

# EASYARC<sup>®</sup> 6013



## CONFORMANCE:

- AWS A5.1-2004 : E6013
- ASME SFA-5.1 : E6013

## APPROVALS:

ABS:2 LR:2 BV:2

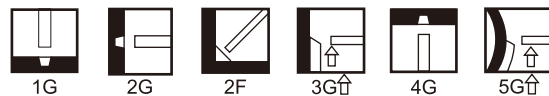
## APPLICATIONS:

EASYARC<sup>®</sup> 6013 can be used for the welding of mild steel. Especially suitable for sheet metal welding, tack welding and other types of welding which require a smooth and clean bead appearance.

## PRODUCT FEATURES:

EASYARC<sup>®</sup> 6013 is an all-position (excluding vertical down), rutile electrode for mild steel. It welds on AC or DC with excellent performance and easy restrike features.

## WELDING POSITIONS:



## REDRYING:

EASYARC<sup>®</sup> 6013 electrodes normally do not require reconditioning before use if stored correctly. If moisture appears to be a problem, redry electrodes from the opened containers in heated cabinets at 275±75°F (130±20°C) for 60-90 mins. Clean the base metal. For improved impact properties, avoid use of excessive amperage levels.

## ADVANTAGE LINCOLN:

- All-position (excluding vertical down) electrode for the welding of mild steel.
- Excellent choice for sheet metal lap and fillet welds.
- Easy slag removal.
- Manufactured under a quality system certified to ISO 9001 requirements.

# EASYARC® 6013

## DIAMETERS / STANDARD PACKAGING

Dia. x Length (mm x mm)	Weight / Inner box (KG)	Weight / Outer carton (KG)
2.5 x 300	5	20
3.2 x 350	5	20
4.0 x 350	5	20
5.0 x 350	5	20

Please contact your local Lincoln Electric sales office for more alternative types of packaging.

## WELD DEPOSITE CHEMICAL COMPOSITIONS (Wt-%) -- TYPICAL

PRODUCTS		C	Si	Mn	P	S
EASYARC® 6013	Requirements AWS E6013 (%)	0.20	1.00	1.20	---	---
	Typical Value	0.06	0.17	0.37	<0.030	<0.020

## ALL WELD METAL MECHANICAL PROPERTIES -- TYPICAL

Lincoln Electrodes		Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Charpy V-Notch (Joules) 0°C
EASYARC® 6013	AWS Requirements	min. 330	min. 430	min. 17	Agency Requirements Grade 2 (All Deposited Metal)----- 47 J min.
	Typical value	415	480	24	Agency Requirements Grade 2 (Butt Welding)----- 34 J min. Typical Test Results for EASYARC® 6013----- 70-90 J

## RECOMMENDED WELDING PARAMETERS

		2.5 x 300	3.2 x 350	4.0 x 400	5.0 x 400
Current (A)	AC	50-80	80-120	150-190	180-240
	DC±	50-80	80-100	110-150	140-200

### Customer Assistance Policy

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customers particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has not been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to change - This information is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.com.cn](http://www.lincolnelectric.com.cn) for any updated information.

### Authorized Distributor:

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