

Product: **SPARK 6013**

Classification: AWS/ASME SFA-5.1 E 6013
 DIN 1913 E 43 22 R (C) 3
 EN499 E 38 0 RC 11

Application/Properties: General-purpose electrode for assembly work, workshop and repair welding, specially suited for vertical-down welding. Good gap bridging. Well suited for tack welding. Can be used on galvanized, primer painted and slightly rusted components. For assembly work, electrode can be used in all position without changing current setting. Smooth, slightly concave welds blending into base metal without undercut. Slag partly self releasing.

Suitable for:

Unalloyed structural steel: St33 to St52-3
 Boiler Plates: HI, HII, 17Mn4
 Pipe Steels: to St52.4, St35.8 to 17Mn4, StE210.7 to StE360.7 including corresponding TM-grades.
 Fine Grain Structural Steels: StE255 to StE355, WStE255 to WStE355.
 Shipbuilding Steels: A, B.
 Cast Steel: GS-38 to GS-52

**Sizes and Currents
 AC or DC:**

| Diameter | Length | Current (A) |
|----------|--------|-------------|
| 2.6mm | 300mm | 70 - 90 |
| 3.2mm | 350mm | 90 - 130 |
| 4.0mm | 350mm | 130 - 180 |
| 5.0mm | 350mm | 180 - 230 |

**FOR POSITIONAL WELDING A
 MAXIMUM OF 4 MM SIZE IS RECOMMENDED.**

Weld metal analysis:

| C | Si | Mn |
|------|-----|-----|
| 0.08 | 0.3 | 0.5 |

**Mechanical properties
 of all weld metal:**

| | |
|-------------------|------------------------------|
| Yield Strength | >390 N/mm ² |
| Tensile Strength | 470 - 590 N/mm ² |
| Elongation L.=5D. | >22% |
| Impact Strength | 80 J at +20°C 50 J at 0°C |

| | |
|-----------------------|-------------------------------------|
| 2.6, 3.2, 4.0 & 5.0mm | 4x5kg. packet/carton 1 MT/pallet |
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