

## Classifications

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

## Characteristics and typical fields of application

Rutile-cellulosic electrode with good weld ability in all positions including vertical down. Excellent gap-bridging and arc-striking ability. For tack welding and load fit ups. General purpose for industry and trade, assembly and shop welding

## Base materials

Steels up to a yield strength of 420 MPa S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, shipbuilding steels: 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; A 633 Gr. A, C; A 711 Gr. 1013 API 5 L Gr. B, X42, X52

## Typical analysis


	C	Si	Mn
wt.-%	0.08	0.4	0.5

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

Condition	Yield strength R <sub>e</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact energy ISO-V KV J	
	MPa	MPa	%	20°C	±0°C
u	440 (≥ 420)	540 (≥ 500 – 640)	22 (≥ 20)	80	55 (≥ 47)

u untreated, as welded

## Operating data

	Polarity	DC – / AC	Dimension mm	Current A	
	Electrode identification	Q E 6013 RC / 6013 / E 42 0 RC		2.0 × 300	40 – 60
				2.5 × 300	60 – 100
				2.5 × 350	60 – 100
				3.2 × 350	90 – 140
				4.0 × 350	150 – 190
				5.0 × 450	190 – 240

## Approvals

TÜV (12677), DB (10.014.50), DNV, CE