



# MILD STEEL ELECTRODES

## E6013

CWB to CSA W48-14  
 Classification: E4313  
 AWS/ASME A5.1 - 04 E6013

### Suitable welding positions



### Typical applications

Covering is high titania type; common welding applications include light to medium construction (in all position) and pipe welding, very good operator appeal. Welding of steel sheet structures, light structural steel, automobile bodies and machinery guards.

### Characteristics on usage

- Excellent strike and re-striking properties
- Very good slag removal, arc transfer and bead appearance without undercut
- Re-dry the electrode at 70-100 °C for 30-60 minutes prior to use

### Typical chemical composition of all-weld-metal(%)

C	Si	Mn	p	S	Cr	Ni	Mo
0.06	0.35	0.40	0.02	0.011	0.03	0.02	0.01

### Minimum typical mechanical properties of all-weld-metal

Yield Strength		Tensile Strength		Elongation	Impact Value
430 MPa	62 ksi	490 MPa	71 ksi	28%	60J (0° C)

### Dimensions and recommended currents

Vanguard Code	Diameter		Length		Amperage	
	inches	mm	inches	mm	F & HF	VU&OH
6182 2400	3/32	2.6	13.8	350	60 - 80	60 - 90
6182 3200	1/8	3.2	13.8	350	80 - 130	80 - 110
6182 4000	5/32	4.0	15.7	400	130 - 180	90 - 140
—	3/16	5.0	15.7	400	160 - 220	120 - 190
—	1/4	6.0	20.0	450	210 - 280	—

### Standard packaging

Sleeve		Master Carton		Pallet	
4.5 Kgs	10 Lbs	22.5 Kgs	50 Lbs	1,125 Kgs	2,500 Lbs