

**E6013 is a mild-steel, all position, general purpose cellulose-base rod. It operates on AC or DC welding current and works well on low voltage AC machines.**

**E6013 is an excellent choice where there is poor fit-up in the joint. It deposits easily and smoothly producing medium to shallow penetration. Small sizes are well adapted to low heat on thin metals. Medium to heavy slag is easily removed and provides for excellent weld cleaning action during the welding process.**

**E6013 is a great selection for all types of mild steel fabrications or repairs where ease of operation and good bead appearance are required.**

#### **Typical Applications**

- General-purpose fabrication • Metal buildings and structures
- Machine parts • Shaft buildup

#### **AWS Specification**

AWS A5.1/A5.1M:2004  
AWS Classification E6013

#### **Welding Current**

AC - DC

#### **Typical Wire Chemistry**

C 0.20

Mn 1.20

Si 1.00

P \*N.S.

S \*N.S.

Ni 0.30

Cr 0.20

Mo 0.30

V 0.08

Combined Limit

for Mn+Ni+Cr+Mo+V \*N.S.

#### **Typical Mechanical Properties**

(As Welded)

Yield Strength,ksi 48

Tensile Strength,ksi 60

Elongation%, min 17

#### **Welding Positions**

F, V, OH, H

#### **Available Diameters**

1/16", 5/64", 3/32", 1/8", 5/32" & 3/16"

#### **Operating Range in Amps**

1/16" 20 - 40

5/64" 25 - 60

3/32" 45 - 90

1/8" 80 - 130

5/32" 105 - 180

3/16" 150 - 230

\*N.S. means Not Specified  
SINGLE VALUES LISTED ARE MAXIMUM