

S-6013.V

TYPE : Rutile-Cellulosic

AWS A5.1 / ASME SFA5.1 E6013

JIS Z3211 E4313

EN ISO 2560-A - E38 0 RC 1 1

SWAW

Applications

S-6013.V can be used for welding of steel sheet structures in ships, railway vehicles, and cars, surface dressing of heavy steel structures. Filling up welding of cast steel.

Characteristics on Usage

S-6013.V is a Rutile-Cellulose type electrode, remarkably improved in workability. This electrode is suitable for welding of small thin pipes. It is also suitable for vertical-down welding.

Notes on Usage

- ① In case of vertical downward welding, manipulate the electrode, keeping its tip in contact with base metal as shown in the sketch.
- ② Dry the electrodes at 70~100°C (158~212°F) for 30~60 minutes before use.

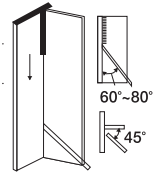
Welding Position



1G 2F 3G(3D)
(PA) (PB) (PG)

Current

AC or DC ±



Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.09	0.32	0.48	0.017	0.012

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
460 (66,700)	550 (79,800)	27.5	0 (32)	65 (48)

Approval

KR, ABS, LR, NK, CWB, TÜV

I Packing

Packet 5 kg (11 lbs)
Carton 5 kg (11 lbs) × 4 : 20kg(44 lbs)

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm(in)	350 (14)	350 (14)	400 (16)	400 (16)
F,V-down	60~100	100~140	140~190	190~240