

## XP E6013

MILD STEEL 

### CLASSIFICATIONS

EN ISO 2560-A	AWS A5.1
E 38 0 R 12	E6013

### KEY FEATURES AND APPLICATIONS

- Rutile type medium coated electrode ideal for welding thin sheet metals (<5mm).
- Provides a minimum yield strength of 380 MPa.
- Stable arc, low spatter, smooth weld bead appearance and self-releasing slag.
- Excellent impact notch toughness at 0°C.
- Re-drying not generally required. If necessary 110°C for 1 hour.

### BASE MATERIALS

S185 S355J0, P235GH, P265GH, P295GH, P235TR2 P355T2, P235G1TH, P255G1TH, L210 L360NB, S255N S355N, GE 200, GE 240

St 33 St 52 3, H I, H II, 17Mn4, St 37.4 St 52.4, St 35.8, St 45.8, StE 210.7 StE 360.7, StE 255 StE 355, GS 38, GS 45, AH 32, EH 36, A, B, D

### CHEMICAL COMPOSITION OF ALL-WELD METAL % - TYPICAL VALUES

C	Mn	Si	P	S	Ni	Cr	Mo	V
0.076	0.44	0.32	0.024	0.014	0.018	0.016	0.004	0.008

### MECHANICAL PROPERTIES OF ALL-WELD METAL - TYPICAL VALUES

Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Charpy V-Notch (J)	Test Temperature
418	520	25	71	0°C

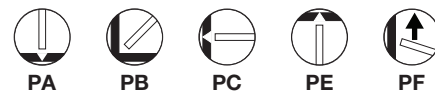
Test data for mechanical properties are not guaranteed since actual as welded conditions depend on numerous variables

### OPERATING DATA

#### Polarity

DC (-)  AC

### WELDING POSITIONS



### WELDING PARAMETERS

Diameter x Length (mm)	2.5 x 350	3.2 x 350	4.0 x 350
Current (A)	60 - 90	90 - 130	140 - 180

### PACKAGING AND AVAILABLE SIZES

Part Number	Diameter x Length (mm)	Packet Weight (kg)	Pieces per Packet (-)	Carton Weight (kg)
XP10115	2.5 x 350	5	274	15
XP10118	3.2 x 350	5	166	15
XP10121	4.0 x 350	5	108	15

SOLD AS CARTON ONLY