

**Classifications**

<b>EN ISO 2560-A</b>	<b>AWS A5.1 / SFA-5.1</b>
E 38 0 RR 1 2	E6013

**Characteristics and typical fields of application**

Thick rutile coated stick electrode with good weld ability in all positions except vertical down. The electrodes produces a soft arc for a smooth weld bead, minimum spatter formation and an easy slag removal leads to less post weld cleaning. Fine ripped clean weld surface.

**Base materials**

Steels up to a yield strength of 380 MPa (52 Ksi)

S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, ship building 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.-%	0.07	0.3	0.5

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

Yield strength $R_{p0.2}$	Tensile strength $R_m$	Elongation A ( $L_0=5d_0$ )	Impact energy ISO-V KV J		
MPa	MPa	%	20°C	0°C	
420 ( $\geq 380$ )	500 ( $\geq 470 - 600$ )	26 ( $\geq 20$ )	75 ( $\geq 60$ )	60 ( $\geq 47$ )	75

u untreated, as welded

**Operating data**

	<b>Polarity</b>	DC- / AC	<b>Dimension mm</b>	<b>Current A</b>
	<b>Electrode identification</b>	FOX SUM 6013 E 38 0 RR	2.5 × 350	60 - 100
			3.2 × 350	90 - 130
			4.0 × 350	110 - 170
			5.0 × 450	170 - 240

**Approvals**

CE