

ArcTrode® | E6013 RC

Rutile ELECTRODE/ SMAW

Standards

EN/ISO-Standard - 2560-A
EN/ISO-Classification - E 42 0 RC 11

AWS-Standard - A5.1
AWS-Classification - E6013

Features and Applications

- Rutile-cellulosic electrode with good weldability in all positions.
- Exceptional arc stability and reduced spatter for decreased cleaning time.
- Suitable for low open circuit voltage transformers (min. OCV 42V).
- Typical applications include assembly, workshop and repair welding of mild and low-alloyed steels.
- Re-drying not generally required. If necessary 100-110°C for 1 hour.
- **Test Certificates can be found online @wilkinsonstar247.com**



Typical Base Materials

235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, shipbuilding 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*

* Illustrative, not exhaustive list

Welding Positions

EN ISO 6947 - PA, PB, PC, PD, PE, PF, PG

Polarity

AC; DC (+/-)

Welding Parameters

Ø mm	2.50	3.20	4.00
Current (A)	50-90	80-130	140-190

Mechanical Properties

Tensile Strength (N/mm ²)	Yield Strength (N/mm ²)	Elongation (%)	Impact Strength (J)	Test Temperature
535	445	24	≥50	0°C

Mechanical properties are approximate and may vary based on the heat, welding parameters and other factors.

Analysis of all-weld metal % (Typical)

C %	Si %	Mn %	P %	S %
0.08	0.40	0.45	0.020	0.015

Packaging Data

Part No.	Diameter x Length Ø (mm)	Packet Weight (Kg)	Electrode Pieces Per/Package	Carton Weight (Kg)
8011100200	2.50 x 350	5	~265	15
8011100203	3.20 x 350	5	~170	15
8011100206	4.00 x 350	5	~110	15

Liability: Whilst all reasonable efforts have been made to ensure the accuracy of the information contained, this information is subject to change without notice and can be only considered as suitable for general guidance.

