

Lincoln 6013

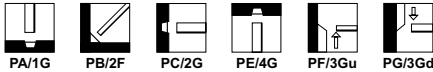
CLASSIFICATION

AWS A5.1	E 6013	A-Nr	1
ISO 2560-A	E 38 A R 11	F-Nr	2
		9606 FM	1

GENERAL DESCRIPTION

Rutile medium coated MMA electrode for a wide range of mild steel applications
 Suitable for welding on thin sheets
 High performances for steelwork, workshop and maintenance welding with easy operability
 Smooth welds, self-releasing slag and good gap bridging
 Very good weldability on AC and DC+

WELDING POSITIONS (ISO/ASME)



CURRENT TYPE

AC / DC+/-

APPROVALS

BV	DNV	LRS
2	2	2M

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S
0.09	0.4	0.4	≤0,03	≤0,03

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J) 0°C
Required: AWS A5.1 ISO 2560-A Typical values	min. 330 min. 420	min. 430 500-640	min. 17 min. 20	not required min. 47
AW	380	470-600	≥20	≥47

PACKAGING AND AVAILABLE SIZES

	Diameter (mm)	2.0	2.5	3.2	4.0
	Length (mm)	300	350	350	350
Carton	Pieces / unit	325	250	170	105
	Net weight/unit (kg)	3.57	4.63	5.03	4.50
		176	145	95	65
		1.93	2.68	2.8	2.78

Identification Imprint: 6013

Tip Color: none

Lincoln 6013: rev. C-EN03-14/03/22

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MATERIALS TO BE WELDED

Steel grades/Code	Type
General structural steels	
EN 10025	S185, S235, S275
Ship plates	
ASTM A 131	Grade A, B, D, AH32
Cast steels	
EN 10213-2	G P 240R
Pipe material	
EN 10208-1	L210, L240, L290
EN 10208-2	L240, L290
API 5LX	X42, X46
EN 10216-1/EN10217-1	P235, P275
Boiler & pressure vessel steels	
EN 10028-2	P235, P265, P295
Fine grained steels	
EN 10025 part 3	S275
EN 10025 part 4	S275

CALCULATION DATA

Sizes Diam. x length (mm)	Current range (A)	Weight/ 1000 pcs (kg)
2.0x300	50-70	11.80
2.5x350	60-85	18.74
3.2x350	100-125	29.73
4.0x350	130-170	44.32

*Stub end 35mm

WELDING PARAMETERS, OPTIMUM FILL PASSES

Diameter (mm)	Welding positions			
	PA/1G	PB/2F	PC/2G	PE/4G
2.0	50A			
2.5	100A	95A	85A	85A
3.2	130A	120A	115A	105A
4.0	185A	185A	160A	130A

REMARKS / APPLICATION ADVICE

Best choice for welding thin plates.