



# Product Data Sheet

# ESAB Xpert 6013

E 'Manual metal-arc welding'  
ESAB-MÓR Kft Hungary

Prepared by J-P Ernoult	Qualified by P-O Oskarsson	Approved by J-P Ernoult	Reg no EN008137	Cancelling None	Reg date 2018-10-05	Page 1 (2)
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## REASON FOR ISSUE

New Product.

## GENERAL

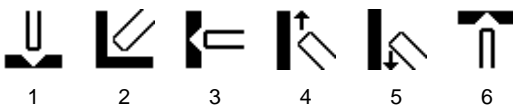
General purpose rutile electrode.

Min AC OCV: 50

Coating Type: Rutile-cellulosic covering

Polarity: AC, DC+-

## WELDING POSITIONS



## CLASSIFICATIONS Electrode

SFA/AWS A5.1 E6013  
EN ISO 2560-A E 38 0 RC 11

## APPROVALS

CE EN 13479

## CHEMICAL COMPOSITION

### All Weld Metal (%)

	Min	Max
C	0.05	0.12
Si	0.10	0.50
Mn	0.15	0.65
P		0.030
S		0.030
Cr		0.20
Ni		0.30
Mo		0.30
V		0.08

## MECHANICAL PROPERTIES OF WELD METAL

Properties	ISO		AWS
	As welded Min	Max	As welded Min
Rp0.2 (MPa)			330
ReL (MPa)	380		
Rm (MPa)	470	600	430
A4 (%)			17
A5 (%)	20		
Charpy V at 0°C (J)	47		



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## ECONOMICS & CURRENT DATA

Dimension (mm) Ø x Length	Current (A)		W	η	N	B	H	T	U	Welding Positions
	Min	Max								
2.5 x 350	60	100	1.8	95	0.65	86	0.80	50	22	1,2,3,4,5,6
3.2 x 350	80	150	2.9	95	0.65	53	1.30	57	22	1,2,3,4,5,6
4.0 x 350	100	200	4.5	95	0.60	39.0	1.60	65	22	1,2,3,4,5,6
5.0 x 450	150	290	9.0	95	0.60	31	2.30	114	24	1,2,3,4,5,6

**W** = Weight (kg / 100 electrodes)

**η** = Efficiency (g weld metal x 100 / g core wire)

**N** = Effective value (kg weld metal / kg electrodes)

**B** = Changes (number of electrodes / kg weld metal)

**H** = Deposit rate at 90% of max current (kg weld metal / hour arc time)

**T** = Fusion time at 90% of max current (s / electrode)

**U** = Arc voltage (V)