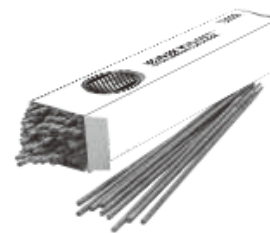


MILD STEEL STICK ELECTRODE

EASYARC™ 6013



EASYARC™ 6013 is an all-position (excluding vertical down), rutile electrode for mild steel. It welds on AC or DC with excellent performance and easy restrike features.

CONFORMANCE

AWS A5.1-2004 : E6013

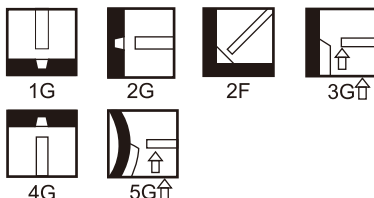
ASME SFA-5.1 : E6013

APPLICATION

EASYARC™ 6013 can be used for the welding of mild steel.

Especially suitable for sheet metal welding, tack welding and other types of welding which require a smooth and clean bead appearance.

WELDING POSITIONS



APPROVALS

ABS: 2 LR: 2 BV: 2

ADVANTAGE LINCOLN

- All-position(excluding vertical down) electrode for the welding of mild steel.
- Excellent choice for sheet metal lap and fillet welds.
- Easy slag removal.
- Manufactured under a quality system certified to ISO 9001 requirements.

GUIDELINES FOR USE

- EASYARC™ 6013 electrodes normally do not require reconditioning before use if stored correctly.
- If moisture appears to be a problem, redry electrodes from the opened containers in heated cabinets at 275±75°F (130±20°C) for 60-90 mins.
- Clean the base metal.
- For improved impact properties, avoid use of excessive amperage levels.

PACKAGING

The electrodes are placed inside packets and then sealed in plastic. 4 packets of electrodes are then placed inside a carton. For large shipments, the cartons are securely stacked on wooden pallets and covered with shrink-wrap plastic.

DIAMETERS/PACKAGING

Diameter × Length (mm)	Weight (kg)		Packet per Carton	Product No.
	Packet	Carton		
2.5 × 300	5	20	4	CC010201
3.2 × 350	5	20	4	CC010202
4.0 × 400	5	20	4	CC010203
5.0 × 400	5	20	4	CC010204

MECHANICAL PROPERTIES, ALL WELD METAL

	Yield Strength Mpa	Tensile Strength Mpa	Elongation (%)
Required AWS E6013	min.330	min.430	min.17
Test Results	415	480	24

* Retail packaging is available.

Charpy V-Notch (Joules)	0°C
Agency Requirements Grade 2 (All Deposited Metal)	47 J min.
Agency Requirements Grade 2 (Butt Welding)	34 J min.
Typical Test Results for EASYARC™ 6013	70-90 J

Charpy V-notch impact tests can exhibit considerable variability depending upon the base plate, welding procedure, V-Notch location within the weld, and many other factors. Please contact your Lincoln sales representative for results or recommendations if your application has special requirements or considerations.

CHEMICAL COMPOSITION, ALL WELD METAL

	C	Mn	Si	S	P
Requirements AWS E6013(%)	0.20	1.20	1.00	Not Specified	Not Specified
Typical Values(%)	0.06	0.37	0.17	<0.020	<0.030

RECOMMENDED WELDING CURRENT(AC, DC±)

Diameter × Length (mm)		2.5 x 300	3.2 x 350	4.0 x 400	5.0 x 400
Current (A)	AC	50-80	80-120	150-190	180-240
	DC±	50-80	80-100	110-150	140-200

Customer Assistance Policy

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customers particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has not been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to change - This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com.cn for any updated information.


**THE NANJING
LINCOLN ELECTRIC
Co., LTD**

No.2, Qiande Road, Jiangning
Science Park, Jiangning District,
Nanjing, Jiangsu, China 211100
TEL: +86-25-8645 2736 8418 8377
FAX: +86-25-8641 8809
www.lincolnelectric.com.cn

Publication CC1.001.EN Stick Rod
07/11

Authorized Distributor: