

CEWELD E 6013 Fall

TYPE Rutile cellulosic electrode for welding in all positions. (Type E 42 0)

APPLICATIONS CEWELD® E 6013 Fall was specially developed for maintenance and repair work in shipbuilding and ship repair. As well for similar work on poorly prepared seams in structural engineering.

PROPERTIES CEWELD® 6013 Fall has excellent ignition and re-ignition properties and can be easily welded with small transformers (42 V). The slag solidifies surprisingly quickly, which is why it is used particularly in a vertical down position with high speed and deep penetration.

CLASSIFICATION

AWS	A 5.1: E 6013
EN ISO	2560-A: E 42 0 RC 11
F-nr	2
FM	1

SUITABLE FOR **Rp < 420 MPa (60ksi) ISO 15608: 1.1 (ReH < 275 MPa), 1.2 (275 < ReH < 360 MPa), 1.3 (ReH > 360 MPa < 420 MPa)**
 1.0035, 1.0038, 1.0039, 1.0044, 1.0112, 1.0116, 1.0130, 1.0145, 1.0253, 1.0254, 1.0255, 1.0258, 1.0259, 1.0319, 1.0345, 1.0345, 1.0345, 1.0348, 1.0352, 1.0418, 1.0420, 1.0425, 1.0425, 1.0425, 1.0451, 1.0452, 1.0453, 1.0457, 1.0459, 1.0460, 1.0460, 1.0461, 1.0486, 1.0490, 1.0491, 1.0619, 1.1100, 1.0409, 1.0421, 1.0426, 1.0429, 1.0430, 1.0436, 1.0473, 1.0481, 1.0482, 1.0484, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, 1.8902, 1.8912, 1.8932
 S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, L415NB, L415MB, WStE 380, WStE 420, S420NL
 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, 70; A 633, Gr. A, C; A 711 Gr. 1013; API 5 L Gr. B, X42, X52, X60

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S
0.08	0.4	0.6	0.02	0.02

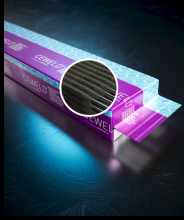
MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	
				0°C	Hardness
As Welded	450	560	22	67	HRC

REDRYING 140°C / 1 hr

CURRENT TYPE: AC, DC+/-

GAS ACC. EN ISO 14175



CEWELD E 6013 Fall

E 6013 FALL 2,0 X 300MM	Packaging	KG/unit	EanCode
	Can	2,4	8720663400208
E 6013 FALL 2,5 X 350MM	Packaging	KG/unit	EanCode
	Vacuum	2,0	8720682050507
E 6013 FALL 3,2 X 350MM	Packaging	KG/unit	EanCode
	Vacuum	2,1	8720682050514
E 6013 FALL 4,0 X 350MM	Packaging	KG/unit	EanCode
	Vacuum	2,2	8720682050521
E 6013 FALL 5,0 X 350MM	Packaging	KG/unit	EanCode
	Vacuum	,2,	8720682050538