



CEWELD E 6013 Root

TYPE Rutile basic electrode for SMAW welding. (Type E 38 2)

APPLICATIONS CEWELD® E 6013 is a classic rutile- basic stick electrode preferably for welding in the weld root area.
Areas of application are: Shipbuilding, construction, buildings, pipe welding

PROPERTIES CEWELD® E 6013 Root is a thick basic-rutile coated electrode for welding low alloyed steels with tensile strength up to 510 MPa. Recommended for root welding in pipelines due to excellent welding properties. The weld metal deposit has high mechanical properties and can be used for a wide range of materials.

CLASSIFICATION

AWS	A 5.1: E 6013
EN ISO	2560-A: E 38 2 RB 12
F-nr	2
FM	1

SUITABLE FOR

Re ≤ 380 MPa (55 ksi) ISO 15608: 1.1 (ReH < 275 MPa) 1.2 (275 < ReH < 360 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, 1.0427, 1.0432, 1.0446, 1.0451, 1.0452, 1.0453, 1.0457, 1.0459, 1.0460, 1.0460, 1.0461, 1.0486, 1.0490, 1.0491, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, 1.1138, 1.5419, 1.8948
 C 22.8 S1, S185, S235JRG2, S235JR S235JRH, S275JR, P235S, S235J2G3, P265S, S275J2, P235TR1, P235TR2, P265TR1, P265TR2, P235GH, P235GH, P235GH, P195GH, P245GH, L245ME, GE200, P265GH, P265GH, P265GH, C 22.3, C 21, GE240, P215NL, P255QL, P265NL, L245NE, C 22.8, P250GH, P275N, S275N, S275NL, GP240GH, P275SL, 21 Mn 6, StE 320.7, St 52.0, P280GH, (X42ME) L290ME, P305GH, P355GH, P295GH, L290NE, S355N, S355NL, P355N, P355NL1, S355J2G3, G21Mn5, G20Mo5, X52QE,
ASTM: A 27 u. A36 Gr. all; A214; A 242 Gr.1-5; A266 Gr. 1, 2, 4; A283 Gr. A, B, C, D; A285 Gr. A, B, C; A299 Gr. A, B; A328; A366; A515 Gr. 60, 65, 70; A516 Gr. 55; A570 Gr. 30, 33, 36, 40, 45; A 572 Gr. 42, 50; A606 Gr. Alle; A607 Gr. 45; A656 Gr. 50, 60; A668 Gr. A, B; A907 Gr. 30, 33, 36, 40; A841; A851 Gr. 1, 2; A935 Gr.45; A936 Gr. 50;
 API 5 L Gr. B, X42-X52

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S
0.1	0.2	0.5	0.02	0.02

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				-20°C	0°C	
As Welded	400	500	25	50	65	HRc

REDRYING 140°C / 1 hr

GAS ACC. EN ISO 14175



CEWELD E 6013 Root

E 6013 ROOT 2,5 X 300MM	Packaging	KG/unit	EanCode
	Can	2,6	8720663400277
E 6013 ROOT 3,2 X 350MM	Packaging	KG/unit	EanCode
	Can	2,6	8720663400284
E 6013 ROOT 4,0 X 450MM	Packaging	KG/unit	EanCode
	Can	3,3	8720663400291