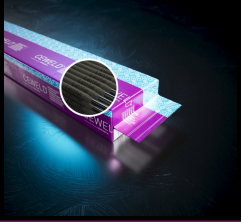


CEWELD E 6013 Fall

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