Mild Steel Stick Electrodes

blume®

E6013

Code & Specification

ASME SFA/AWS A5.1 E6013

Description

BLUME® E6013 is a mild steel stick electrode. Operable with low amperages on sheet metal. Excellent bead appearance.

Applications

BLUME® E6013 is used for welding of sheet metal and for irregular short welds that change position. Typically used for maintenance or repair welding. Can be used on small AC Welders with low open circuit voltage.

Mechanical Properties

	As-welded
Yield Point, MPa	400 - 440
Tensile Strength, MPa	460 - 515
Elongation, %(L=4d)	20 - 23

Charpy V-Notch Impact Properties

Testing Temp.	**As-welded (J)**
-29 °C (-20ºF)	37 - 76

Undiluted Weld Metal Analysis (wt%)

C	**Mn**	**Si**	**S**	**P**
0.04 - 0.07	0.30 - 0.45	0.15 - 0.25	≤ 0.015	≤ 0.015
Ni	**Cr**	**Mo**		
≤ 0.07	0.02 - 0.04	≤ 0.02		

Packaging

⌀ x L	Wt./Carton	Carton/Box	Net wt./Box
2.5mm x 300mm (3/32” x 12”)	2.5 kgs (5.5 lbs)	8	20 kgs (44 lbs)
3.2mm x 350mm (1/8” x 14”)	2.5 kgs (5.5 lbs)	8	20 kgs (44 lbs)
4.0mm x 400mm (5/32” x 16”)	2.5 kgs (5.5 lbs)	8	20 kgs (44 lbs)

Suggested Welding Parameters

⌀ x L	AC	DC±
2.5mm x 300mm (3/32” x 12”)	75 - 115	70 - 105
3.2mm x 350mm (1/8” x 14”)	110 - 140	100 - 135
4.0mm x 400mm (5/32” x 16”)	160 - 200	145 - 180

Approvals

CE

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