

CODING	AWS - A 5.1: E6013
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Characteristics: Edison - 6013 is a medium coated Rutile type, all position general-purpose electrode which gives uniform deposition, smooth arc characteristics and good re-striking properties. The electrode operates on AC as well as DC power source.

Applications: For all kind of mild steel structures like ship hulls, tanks & vessels, bridges, railway wagons, steel frames & grills, truck bodies etc.

Typical Mechanical Properties

	Values
Yield Strength, N/mm ²	330 Min.
Tensile Strength, N/mm ²	410 – 540
% Elongation	20 Min.
Impact (CVN) at 27 ^o C	47 J Min.

Weld Metal Chemistry (%):

C	Mn	Si	P	S
0.12 max	0.60 max	0.40 max	0.040 max	0.040 max

Current Condition

Size (mm)	Current (Amp.): AC, DC (+)
2.50 x 350	60 – 90
3.15 x 350	100 – 140
4.00 x 450/350	140 – 200