



S. R. Industries

STAR ARC E6013

E6013 is a mild-steel, all position, general purpose cellulose-base rod. It operates on AC or DC welding current and works well on low voltage AC machines. E6013 is an excellent choice where there is poor fit-up in the joint. It deposits easily and smoothly producing medium to shallow penetration. Small sizes are well adapted to low heat and thin metals. Medium to heavy slag is easily removed and provides for excellent weld cleaning action during the welding process.

Typical Applications : General purpose fabrication, metal buildings and structures, machine parts, shaft buildup.

AWS Class : E6013	Classification : AWS A5.1/A5.1M:2004
Alloy : E6013	ASME SFA A5.1
Welding Position : F, V, OH, H	Current : DC, AC, DCEP, DCEN
Tensile Strength, kpsi:	60 min
Yield Strength, kpsi:	48 min
Elongation in 2" (%):	17 min

Typical Wire Chemistry as per AWS A5.1 (single values are maximum)

C	Mn	Si	P	S	Ni	Cr	Mo	V	Combined Limit for Mn+Ni+Cr+Mo+V
0.20	1.20	1.00	*NS	*NS	0.30	0.20	0.30	0.08	*NS

Not Specified

Typical Welding Parameters				
Diameter		Process	Volt	Amps (V/OH)
in	(mm)			
3/32	(2.4)	SMAW	19-24	40-80
1/8	(3.2)	SMAW	18-23	70-120
5/32	(4.0)	SMAW	20-24	130-160
3/16	(4.8)	SMAW	20-23	140-220

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