



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	
					-20°C	0°C
	As Welded	400	500	25	50	65
					Hardness	
					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