

# NST E 6013

AWS: A5.1 E 6013

EN ISO 2560-A: E 42 0 1RC 11



## Rutile all round electrode for welding low and unalloyed steels.

### General description:

NST E 6013, is a thick coated rutile-cellulose type electrode for welding low and unalloyed steels. Suitable for welding constructions, maintenance and repairing purposes. Excellent welding properties in all welding positions.

### Welding positions:



### Welding current:

DC+/-/AC

### Redrying:

140 °C/1 hour

### Typical chemical composition of all-weld-metal:

C	Si	Mn	P	S					
0,08	0,45	0,65	<0,035	<0,035					

### Diffusible hydrogen content (ml/100g):

### Mechanical properties of all-weld-metal:

Yield and Tensile Strengths			Charpy Impact Test	
Yield Mpa	Tensile Mpa	Elongation %	Charpy V (J) 0 °C	
≥420	500-640	≥22	≥47	

### Guidance - Ampere (DC+/-/AC):

Electrode diameter	2,5 mm	3,2 mm	4,0 mm
Ampere / Volt	60-85	90-135	130-170

### Packaging information:

2,0 x 300 2,0kg pack, carton 12,0kg  
2,5 x 350 2,0kg pack, carton 12,0kg  
3,2 x 350 2,0kg pack, carton 12,0kg  
4,0 x 350 2,0kg pack, carton 12,0kg

### Approvals:

TÜV, CE

### Reference / date:

NST E 6013, English,  
28.01.2016.

Perfect Welding

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