



**Carbon steel welding electrodes**

It is a rutile electrode for all positional welding, with a good weld appearance on both butt and fillet welds for the good flowing properties of the weld metal. Good slag detachability and low spatter. It can still keep a stable arc even at low welding currents, making the electrode suitable for sheet metal welding.

3.2mm

Lot No.: AD4091701

Date: Aug.26.2024

<b>AK E6013</b>	<b>EN ISO 2560-A</b>	<b>AWS A5.1</b>	<b>Certificate number</b>
<b>Welding electrodes</b>	<b>E 35 A R 1 2</b>	<b>E6013</b>	<b>2408-2604</b>

**CHEMICAL COMPOSITION OF WIRE (%)**

	<b>C</b>	<b>Si</b>	<b>Mn</b>	<b>S</b>	<b>P</b>	<b>Ni</b>	<b>Cr</b>	<b>Mo</b>	<b>—</b>	<b>—</b>
<b>%</b>	<b>0.077</b>	<b>0.21</b>	<b>0.46</b>	<b>0.016</b>	<b>0.017</b>	<b>0.001</b>	<b>0.02</b>	<b>0.001</b>	<b>—</b>	<b>—</b>

**THE TESTRESULTS OF MECHANICAL PROPERTY OF DEPOSITED METAL**

<b>Tension Test</b>			<b>Impact test</b>	
<b>Tensile Strength (Mpa)</b>	<b>Yield Point (Mpa)</b>	<b>Elongation (%)</b>	<b>Temp (0C)</b>	<b>Impact Value(J)</b>
<b>482</b>	<b>379</b>	<b>27</b>	<b>0</b>	<b>73/88/91</b>

<b>Bend test—Face</b>	<b>Bend test—Side</b>	<b>Redrying</b>	<b>X Reys Test</b>	<b>Dictionary flux</b>	<b>HRC</b>	<b>HD</b>
<b>OK</b>	<b>OK</b>	<b>—</b>	<b>II</b>	<b>—</b>	<b>—</b>	<b>—</b>

<b>2.0mm (5/64" )</b>	<b>2.5mm(3/32" )</b>	<b>3.2mm(1/8" )</b>	<b>4.0mm(5/32" )</b>	<b>5.0mm(3/16" )</b>
<b>300mm</b>	<b>350mm</b>	<b>350mm</b>	<b>350mm</b>	<b>400mm</b>

**NOTICE:** The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for the use in the field. The manufacturer disclaims any warranty of merchantability of fitness for any particular purpose with respect to its products.

**CAUTION:** Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 550 NW LeJune Road, Miami, FL 33126: OSHA Safety and Health Standards 29 CRF 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.