

ZULFI E 6013

Brand Name & Classification

AWS/ASME SFA-5.1: E6013
DIN 1913: E 43 22 R(C)3
EN499: E 38 0 RC 11

Approvals Grade

ABS
DNV
LRS 2
BV
GL

Properties

General-purpose electrode for assembly work, workshop and repair welding, especially for vertical down welding. Good gap bridging. Well suited for tack welding. Can be used on galvanized, primer painted and slightly rusted components. For assembly work electrode can be used in all positions without changing the current setting. Smooth slightly concave welds blending into base metal without undercut. Slag self-releasing.

Application

Unalloyed structural steel: St33 to St52-3
Boiler plates: HI, HII, 17Mn4
Pipe steels: St52.4, St35.8, StE210.7 to StE360.7 1 including corresponding TM grades
Fine grain structural steels: StE255 to StE 355, WstE255 to WstE 355
Shipbuilding steels: A,B
Cast steel: GS-38 to GS-52

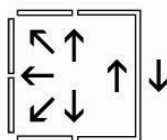
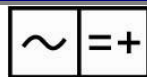
Weld Metal Analysis Typical values

Carbon: 0.08
Silicon: 0.30
Manganese: 0.55

Typical Mechanical properties

Yield Strength	Tensile Strength	Elongation	Impact Strength
>390 N/MM2	470 – 590 N/mm2	> 22 %	80 J at +20 ⁰ c 50 J at 0 ⁰ c

Welding Current & Positions



Current

Dia	Length	Amperes
2.6	350	70-90
3.2	400/450	90-130
4.0	400/450	130-180
5.0	400/450	180-230