

EASYARC™ 6013D

EASYARC™ 6013D is a rutile electrode, especially designed for vertical down welding of mild steel. It welds on AC or DC with excellent performance and easy restrike features.

APPLICATION

EASYARC™ 6013D can be used for the welding of mild steel. Especially suitable for sheet metal vertical down welding, tack welding and other types of welding which require a smooth and clean bead appearance.

CONFORMANCE

AWS A5.1-2004 : E6013
ASME SFA-5.1 : E6013

LINCOLN ADVANTAGE

- Vertical down welding capability
- Excellent choice for sheet metal lap and fillet welds.
- Easy slag removal.
- Manufactured under a quality system certified to ISO 9001 requirements.

WELDING POSITIONS**GUIDELINES FOR USE**

- EASYARC™ 6013D electrodes normally do not require reconditioning before use if stored correctly.
- If moisture appears to be a problem, redry electrodes from the opened containers in heated cabinets at $275\pm 75^{\circ}\text{F}$ ($130\pm 20^{\circ}\text{C}$) for 60-90 mins.
- Clean the base metal.
- For improved impact properties, avoid use of excessive amperage levels.

PACKAGING TYPE

The electrodes are placed inside packets and then sealed in plastic. 4 packets of electrodes are then placed inside a carton. For large shipments, the cartons are securely stacked on wooden pallets and covered with shrink-wrap plastic.

EASYARC™ 6013D**DIAMETERS / PACKAGING**

Diameter × Length (mm × mm)	Weight (kg)		Packet per Carton	Product No.
	Packet	Carton		
2.5 x 300	5	20	4	CC012401
3.2 x 350	5	20	4	CC012402
4.0 x 400	5	20	4	CC012403
5.0 x 400	5	20	4	CC012404

MECHANICAL PROPERTIES --- As Welded

	Yield Strength Mpa	Tensile Strength Mpa	Elongation (%)
AWS E6013 Requirement	Min.330	Min.430	Min.17
Typical Values	435	510	20.5

CHEMICAL COMPOSITION --- As Welded

	C	Mn	Si	S	P
AWS E6013 Requirement (%) Max.	0.20	1.20	1.00	Not Specified	Not Specified
Typical Values (%)	0.08	0.47	0.34	<0.020	<0.030

RECOMMENDED WELDING CURRENT (AC, DC±)

Diameter × Length (mm × mm)		2.5 x 300	3.2 x 350	4.0 x 400	5.0 x 400
Current (A)	AC	50-80	80-120	150-190	180-240
	DC±	50-80	80-100	110-150	140-200

Customer Assistance Policy

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customers particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has not been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

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Subject to change - This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com.cn for any updated information.

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