

Classification			
AWS A5.1	AWS A5.1M	EN ISO 2560-A	EN ISO 2560-B
E6013	E4313	E 38 0 RC 11	E 43 13 A

**Characteristics and typical fields of application**

Rutile-cellulosic electrode engineered for easy operating in all positions including vertical down. Excellent welding properties in AC polarity, good striking and restriking characteristic, sound penetration, flat beads. Popular for general steel construction

**Base Materials**

Steels up to a yield strength of 380 N/mm<sup>2</sup> (52 ksi)  
 S275JR, S235J0G3 - S355J0G3, P235GH, P265GH, P255NH, P235T1, P355T1,  
 P235T2-P355T2, P235G1TH, P255G1TH, L210 - L360NB, L290MB, S235JRS1 - S235J0S1,  
 S235JRS2 - S235J0S2  
 ASTM A36 a. A53 Gr. all; A106 Gr. A, B, C A 135 Gr. A, B; A283 Gr. A, B, C, D; A366; A285  
 Gr. A, B, C; A500 Gr. A, B, C; A570 Gr. 30, 33, 36, 40, 45; A607 Gr. 45; A668 Gr. A, B; A907  
 Gr. 30, 33, 36, 40; A935 Gr.45; A936 Gr. 50; API 5 L Gr. B, X42 - X52

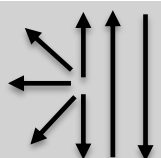
**Typical analysis of All Weld Metal (wt.-%)**

C	Si	Mn
0.06	0.30	0.40

**Mechanical properties of all-weld metal**

Heat Treatment	Yield strength R <sub>e</sub> N/mm <sup>2</sup>	Tensile strength R <sub>m</sub> N/mm <sup>2</sup>	Elongation (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J
	MPa	MPa	%	-0 °C
As Welded	460	530	25	54

**Operating data**

	<p><b>Polarity</b> AC / DCEP/ DCEN</p>	<p>Re-drying not necessary Electrode Identification : <b>Bohler Fox S 6013</b></p>
---	--	--

**Approvals**

ABS, BKI

**Size, Packaging and Electrical Operating Data**

Size mm		Carton Box		Amperage (A)
Ø	Length	Kg / Pack	Kg / Box	
2.50	350	5.0	20.0	60-100
3.25	350	5.0	20.0	90-130
4.00	400 / 450	5.0	20.0	110-170
5.00	450	5.0	20.0	170-240