

Blue GP E6013

General Purpose Electrodes-Mild Steel

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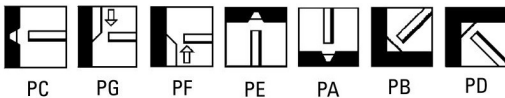
DESCRIPTION

This stick electrode has excellent welding properties in all positions, including vertical down. Suitable for joint welding and repair welding on mild steel in all applications of the metal-working industry and in craft. This electrode is characterised by good bridge ability, easy ignition & re-ignition and low spatter. The result is a smooth, finely rippled seam surface and easy slag removal even on slightly rusty, primed, galvanised base materials and wrought iron.

ADVANTAGES

- Superior Slag Removal
- Excellent Operator Appeal
- Ideal All Positional Welding Capabilities Including Vertical Down
- Smooth and Easy Arc Action

WELDING POSITIONS



CLASSIFICATION

AS/NZS 4855-B - E43 13 A
AWS : A5.1 E6013
ISO 2560-A-E38 0 R 12

CURRENT TYPE

AC / DC (-)

TYPICAL CHEMICAL COMPOSITION OF WELD METAL

| C | Mn | Si | P | S | Fe |
|------|------|------|-------|-------|-----|
| 0.07 | 0.48 | 0.41 | 0.016 | 0.005 | Bal |

TYPICAL MECHANICAL PROPERTIES OF DEPOSITED METAL

| Yield Strength | Tensile Strength N/mm2 | Elongation A 5% | Impact Values Joules |
|----------------|------------------------|-----------------|----------------------|
| 380 | 470-540 | 24 | 60J@00C |

SIZE & RECOMMENDED CURRENT RANGE AC/DC(-)

| Electrode Size (mm) | Electrode Length (mm) | Welding Current Range |
|---------------------|-----------------------|-----------------------|
| 2.5 | 300 | 60-85 |
| 3.2 | 380 | 100-130 |
| 4.0 | 380 | 140-180 |

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