

STICK ELECTRODE

EXTREME E 6013



KEY FEATURES

1. EXCELLENT ARC STABILITY
2. FAST-FREEZE
3. BEAUTIFUL BEAD APPEARANCE
4. EASY SLAG DETACHABILITY
5. WELDING ACCURACY AND EFFICIENCY
6. EXCELLENT FOR POOR FIT-UP
7. QUICK AND EASY CLEAN UP
8. WELDS IN FLAT, HORIZONTAL AND VERTICAL POSITIONS
9. DIRECT CURRENT ELECTRODE POSITIVE (DCEP), AC, OR DIRECT CURRENT ELECTRODE NEGATIVE (DCEN)
10. DIAMETERS: 3/32", 1/8", 5/32", 3/16"

SWAW

CLASSIFICATION

AWS A5-1 : E6013

GENERAL DESCRIPTION

Pak Bridge Extreme E-6013 is a medium coated electrode for a wide variety of mild steel fabrication applications. It has exceptional overall operability and welder appeal, resulting in high quality weld deposits. Excellent in the overhead position and for fillet welding in the horizontal-vertical position. Smooth metal transfer, low spatter and self releasing slag. Smooth weld bead appearance.

APPLICATIONS

Pak Bridge Extreme E-6013 electrode has fast freezing slag. All positional electrode which is very easy to weld, for all light constructional work, including pipework. Suitable for vertical down welding of thin plates. Operates on low open circuit voltage, recommended for tack welding. Good slag detachability and excellent bead appearance. Efficiency 100%.

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD META L

C	Mn	Si	S	P
0.05-0.09	0.03-0.06	≤0.35	≤0.035	≤0.040

MECHANICAL PROPERTIES, OF DEPOSITED METAL

Item	Tensile Strength	Yield Strength	Elongation	Charpy Impact Energy values
Units	Rm(MPa)	ReL(MPa)	A%	at-0°C
General Result	430-550	>330-360	24	47(J)

ELECTRODE SIZE / CURRENT CONDITION / PACKAGING INFORMATION

Electrode Dia (mm)	2.5mm	3.2mm	4.0mm	5.0mm
Electrode length (mm)	300	350	400	400
Current Range	Min.	55A	80A	130A
	Max.	80A	120A	190A
Packing Information Inner Box Weight (No of PKT) Per Carton	2.5kg(8)	5kg(4)	5kg(4)	5kg(4)
Approx. Electrodes Per Pkt.	140	155	90	55

STORAGE AND RE-BAKING

It is recommended that the Pak Bridge Extreme E-6013 electrodes are stored in a dry heated store at a minimum temperature of 18°C, and a maximum relative humidity of 60% Not more than 6 carton should staked on top of one another to avoid damage to the coatings. Re-dry if these electrodes become excessively damp @ 100°C for 1 hour.

WELDING POSITIONS

