

## PRODUCT INFORMATION

**SIFTrode 6013**

EN ISO 2560 E 42 0 RC 11  
EN 13479

AWS A5.1 E 6013

## DESCRIPTION

SIFTrode 6013 is a versatile and general purpose rutile-coated mild steel MMA electrode which runs smoothly and leaves an attractive weld bead. CE approved to EN13479, SIFTrode 6013 offers a smooth arc, low spatter and easy lifting slag to reveal a finely-rippled bead.

## WELDING POSITIONS



Suitable for use in all positions.

## TYPICAL WELD METAL COMPOSITION

C	0.07%
Mn	0.4%
Si	0.4%
S	0.01%
P	0.02%

## TYPICAL MECHANICAL PROPERTIES

Ult Tensile Strength	520 N/mm <sup>2</sup>
Yield Strength	420 N/mm <sup>2</sup>
Elongation	≥24%
Impact Value	≥50J @ 0°

## MATERIAL TO BE WELDED

SIFTrode 6013 is ideal for both butt and fillet joints in a broad variety of general fabrication and repair tasks, including platework, pipe flanges, frames and tubes, as well as construction, structural steels and pressure vessels. It can be used in either DC+, DC- or AC (min OCV 50V) currents/polarities, and should be re-dried at 100°C for 1hr if required.

SIFTrode 6013 can be confidently used on land-based steel structures and general fabrication alike.

## AVAILABLE FORMATS

ELECTRODE RODS		
Dia	2kg	5kg
1.6mm	RE601602	
2.5mm		RE602550
3.2mm		RE603250
4.0mm		RE604050

Current Range	
Dia	Amps
2.5mm	60 – 100
3.2mm	85 – 130
4.0mm	130 – 170

For further information, contact Weldability | Sif technical support on **0870 330 7757** or email [service@weldability-sif.com](mailto:service@weldability-sif.com)



Doc Ref : SIF/PSI/RE601602