

## PRODUCT INFORMATION

### SIFTRODE 6013-R

AWS A5.1 E 6013  
EN ISO 2560 E 42 0 RC 11

### DESCRIPTION

SIFTrode 6013-R is a versatile and general purpose rutile-coated mild steel MMA electrode which runs smoothly and leaves an attractive weld bead. SIFTrode 6013-R can be confidently used on land-based steel structures and general fabrication alike.

### WELDING POSITIONS



Suitable for easy use in all popular welding positions, SIFTrode 6013-R offers a smooth arc, low spatter and easy-lifting slag to reveal a finely-rippled bead.

### TYPICAL WELD METAL COMPOSITION

C	0.08 %
Mn	0.60 %
Si	0.40 %

### TYPICAL MECHANICAL PROPERTIES

0.2% Yield Strength	≥ 420 N/mm <sup>2</sup>
Ult Tensile Strength	≥ 500-640 N/mm <sup>2</sup>
Elongation	~ 20%
Impact Values ISO-V	0° ≥47J

### MATERIAL TO BE WELDED

SIFTrode 6013-R 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 DC+, DC- or AC (min OCV 50V) currents/polarities, and should be re-dried at 100°C for 1hr if required.

### AVAILABLE FORMATS

ELECTRODE RODS (MMA / SMAW)			
Dia	2.5kg Pkt	5.0kg Pkt	Approx Pcs/KG
2.0mm		RE802050	90
2.5mm		RE802550	51
3.2mm		RE803250	31
4.0mm		RE804050	20

CURRENT RANGE	
Dia (mm)	Amps
2.0	30 - 50
2.5	55 - 85
3.2	90 - 135
4.0	130 - 170

For further information, contact Weldability | Sif technical support on **0870 330 7757** or email [service@wholeweld.co.uk](mailto:service@wholeweld.co.uk)



Doc Ref : SIF/PI/RE80