

PRODUCT INFORMATION

SIFTRODE 6013-M

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

DESCRIPTION

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

TYPICAL WELD METAL COMPOSITION

C	0.07 %
Mn	0.40 %
Si	0.40 %
S	0.01 %
P	0.02 %

TYPICAL MECHANICAL PROPERTIES

0.2% Yield Strength	≥ 420 N/mm ²
Ult Tensile Strength	≥ 520 N/mm ²
Elongation	~ 24%
Impact Values ISO-V	0° ≥50J

MATERIAL TO BE WELDED

SIFTrode 6013-M 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/Pkt
2.5mm	RE652525	RE652550	265
3.2mm	RE653225	RE653250	170
4.0mm	RE654025	RE654050	115

CURRENT RANGE	
Dia (mm)	Amps
2.5	60 – 100
3.2	85 – 130
4.0	130 – 170

For further information, contact Weldability | Sif technical support on **0870 330 7757** or email service@wholeweld.co.uk



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