

Mild Steel Electrodes

Alloy: WW6013  
Class: E6013

Certification: AWS A5.1  
ASME SFA A5.1

Alloy: E6013

Weld Process: Shielded Manual Metal Arc Electrodes

AWS Chemical Composition Requirements

Not Specified In AWS Specifications

Deposited Chemical Composition % (Typical)

C = 0.08      Mn = 0.50      Si = 0.40

Recommended Welding Parameters

<u>Diameter</u>	<u>Amperage</u>
3/32"	60 – 110
1/8"	90 – 140
5/32"	110 – 180

Current (AC)

Deposited All Weld Metal Properties %  
(Typical) As-Welded

Yield Strength (PSI)    66,500  
Tensile Strength (PSI)    76,500  
Elongation in 2" (%)    25

Application

Very good weldability in all positions except vertical down.  
Operates with AC, use low amperage.

Deposited Charpy-V-Notch Impact Properties %  
(Typical) As-Welded

44 ft. lbs. (tested at +32°F)

