

## DM6013 Premium Electrode

**Classification: E6013**

AWS A 5.1 / ASME SFA 5.1

**DuraMax DM6013 is a LIGHT MEDIUM COATED RUTILE TYPE  
GENERAL PURPOSE ELECTRODE**

### Characteristics

The electrode is characterized by smooth and stable arc, low spatter, easy slag detachability, fine rippled bead appearance, weld deposit possesses good chemical and mechanical properties.

### Typical Applications on Usage

- 1) Suitable for tank & vessels.
- 2) General fabrication.
- 3) Vehicles.
- 4) Railway wagons and machinery.
- 5) Ship building construction, light structural steel works
- 6) Storage tanks etc.

**RE-DRY CONDITIONS:** Re-Dry the electrode at 120°C for 30-60 minutes, for best results.

### All Weld Chemical Composition (%)

C	Mn	Si	S	P	Ni	Cr	Mo	V
0.20 max	0.40 - 0.80	0.30 max	0.030 max	0.030 max	0.30 max	0.20 max	0.30 max	0.08 max

### Typical Mechanical Properties as Welded

Tensile Strength (n/mm <sup>2</sup> )	Yield Strength (n/mm <sup>2</sup> )	Elongation (%)	Hardness	Ferrite WRC (FN)	CVN Impacts (J)
					@ -30 °C
430-560	330-450	22 -30	-----	3-10 FN	50 - 80 J

### Sizes available and recommended currents (DC +)

SIZE	3/32	1/8	5/32
AMPS	50 ~ 80	80 ~ 120	130 ~ 170

POLARITY: DCEN or AC

DCEN: DC, Electrode Negative (straight polarity) has the least weld penetration

AC: medium weld penetration (can be more spatter)

WELDING POSITIONS: Flat, Horizontal, Overhead, Vertical-up and Vertical-down positions

USE LESS AMPS ON THIN METAL; MORE AMPS ON THICK METALS