

## Classifications

**AWS A5.1 / SFA-5.1**

E6013

## Characteristics and typical fields of application

BÖHLER Q 6013 is a heavily coated electrode for joint welding, generally for machines, cars, car bodies, tanks, vessels, shipbuilding, structural steels, etc. The weld metal can be galvanized.

BÖHLER Q 6013 offers excellent arc start and restrike using power sources with a low open circuit voltage (~80 V). It has a soft and stable arc for welding in all positions except vertical down. It has a uniform flow and low spatter. Smooth, finely rippled seam surface without undercut. The slag is easily detached in AC and DC. This electrode can be used with a wide amperage range.

## Base materials

It can be applied to mild steels with tensile strength up to 60 Ksi (430 Mpa)

ASTM A36, A53, A106, A106, A283, A285, A131 Gr A,B,D y E, API 5L Gr B.


## Typical analysis

	C	Si	Mn
wt.-%	< 0.2	< 1.0	< 1.2

## Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength $R_e$	Tensile strength $R_m$	Elongation A ( $L_0=5d_0$ )	Impacts ISO-V KV ft-lbs
	ksi	ksi	%	- 20°F
u	> 48	> 60	> 17	> 27
u untreated, as welded				

## Operating data

	<b>Polarity</b>	DC ( +/ - ) AC	<b>Dimension</b>	<b>Current A</b>
	<b>Electrode identification</b>	BÖHLER Q 6013	3/32" × 14"	80 - 100
			1/8" × 14"	90 - 130
			5/32" × 14"	140 - 190
			3/16" × 14"	160 - 220

## Approvals