

## PRODUCT INFORMATION

**SIFTRODE 6013**



AWS A5.1 E 6013  
EN ISO 2560 E 42 0 RC 11  
EN 13479

### DESCRIPTION

SIFTrode 6013 is a versatile and general purpose rutile-coated mild steel MMA electrode which runs smoothly and leaves an attractive weld bead. CE approved to EN13479, SIFTrode 6013 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 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 <sup>2</sup>
Ult Tensile Strength	≥ 520 N/mm <sup>2</sup>
Elongation	~ 24%
Impact Values ISO-V	0° ≥ 50J

### MATERIAL TO BE WELDED

SIFTrode 6013 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 either 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	2.0kg Pkt	5.0kg Pkt	Approx Pcs/Pkt
1.6mm	RE601602		285
2.5mm		RE602550	265
3.2mm		RE603250	170
4.0mm		RE604050	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](mailto:service@wholeweld.co.uk)



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