


CEWELD E 6013 T

| TYPE | Dik beklede rutiel elektrode voor het lassen van on- en laaggelegeerd staal | | | | | | | | | | | | | | | | | | | | | |
|---|---|----------------------|-------------------------|----------------------|--------------------|-------------------------|--------------------|----------|-------------------------|---|-----------|------|-----|-----|------|------|------|------|------|-------|------|--|
| TOEPASSINGEN | Scheepsbouw, trailerbouw, constructiewerkzaamheden, montage en reparatie laswerk. | | | | | | | | | | | | | | | | | | | | | |
| EIGENSCHAPPEN | CEWELD® E 6013 T is een dik beklede elektrode voor het verbinden van allerlei soorten staalconstructies in de machinebouw, carrosserie- en wagenbouw, bij de fabricage van schepen en containers in de scheepsbouw. De CEWELD® E 6013 T heeft uitstekende laseigenschappen in alle posities behalve verticaal neergaand. Ontsteekt gemakkelijk en geen spatverlies. Zeer gemakkelijke slakverwijdering. Glad, fijn lasnaadoppervlak en weinig rook. | | | | | | | | | | | | | | | | | | | | | |
| CLASSIFICATIE | AWS | A 5.1: E 6013 | | | | | | | | | | | | | | | | | | | | |
| | EN ISO | 2560-A: E 42 0 RR 12 | | | | | | | | | | | | | | | | | | | | |
| | F-nr | 2 | | | | | | | | | | | | | | | | | | | | |
| | FM | 1 | | | | | | | | | | | | | | | | | | | | |
| GESCHIKT VOOR | <p>Rp < 420 MPa (60ksi) ISO 15608: 1.1 ReH < 275 MPa, 1.2 275 < ReH < 360 MPa, (1.3 ReH > 360 MPa < 420 MPa)</p> <p>1.0035, 1.0038, 1.0039, 1.0044, 1.0112, 1.0116, 1.0130, 1.0145, 1.0253, 1.0254, 1.0255, 1.0258, 1.0259, 1.0319, 1.0345, 1.0345, 1.0345, 1.0348, 1.0352, 1.0418, 1.0420, 1.0425, 1.0425, 1.0425, 1.0451, 1.0452, 1.0453, 1.0457, 1.0459, 1.0460, 1.0460, 1.0461, 1.0486, 1.0490, 1.0491, 1.0619, 1.1100, 1.0409, 1.0421, 1.0426, 1.0429, 1.0430, 1.0436, 1.0473, 1.0481, 1.0482, 1.0484, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, 1.8902, 1.8912, 1.8932</p> <p>S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, L415NB, L415MB, WStE 380, WStE 420, S420NL</p> <p>A, B, D</p> <p>ASTM A 106, Gr. A, B; A 283 Gr. A, C; A 285 Gr. A, B, C; A 501, Gr. B; A 573, Gr. 58, 65, 70; A 633, Gr. A, C; A 711 Gr. 1013; API 5 L Gr. B, X42, X52, X60</p> | | | | | | | | | | | | | | | | | | | | | |
| GOEDKEURINGEN | CE | | | | | | | | | | | | | | | | | | | | | |
| LASPOSITIES |  | | | | | | | | | | | | | | | | | | | | | |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | <table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>V</th> <th>Fe</th> </tr> </thead> <tbody> <tr> <td>0.08</td> <td>0.4</td> <td>0.6</td> <td>0.02</td> <td>0.02</td> <td>0.04</td> <td>0.05</td> <td>0.02</td> <td>0.015</td> <td>Rem.</td> </tr> </tbody> </table> | C | Si | Mn | P | S | Cr | Ni | Mo | V | Fe | 0.08 | 0.4 | 0.6 | 0.02 | 0.02 | 0.04 | 0.05 | 0.02 | 0.015 | Rem. | |
| C | Si | Mn | P | S | Cr | Ni | Mo | V | Fe | | | | | | | | | | | | | |
| 0.08 | 0.4 | 0.6 | 0.02 | 0.02 | 0.04 | 0.05 | 0.02 | 0.015 | Rem. | | | | | | | | | | | | | |
| MECHANISCHE WAARDEN | <table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{p0,2} (MPa)</th> <th rowspan="2">R_m (MPa)</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th colspan="2">0°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>450</td> <td>570</td> <td>25</td> <td colspan="2">66</td> <td>HRc</td> </tr> </tbody> </table> | Heat Treatment | R _{p0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness | 0°C | | As Welded | 450 | 570 | 25 | 66 | | HRc | | | | | |
| Heat Treatment | R _{p0,2} (MPa) | | | | | R _m (MPa) | A ₅ (%) | | Impact Energy (J) ISO-V | | Hardness | | | | | | | | | | | |
| | | 0°C | | | | | | | | | | | | | | | | | | | | |
| As Welded | 450 | 570 | 25 | 66 | | HRc | | | | | | | | | | | | | | | | |
| HERDROGEN | 140°C / 2 hr | | | | | | | | | | | | | | | | | | | | | |
| GAS ACC. EN ISO 14175 | | | | | | | | | | | | | | | | | | | | | | |



CEWELD E 6013 T

E 6013 T 1,6 X 250MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| Can | 2,0 | 8720663400628 |

E 6013 T 2,0 X 300MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| Vacuum | 1,8 | 8720682050583 |

E 6013 T 2,5 X 350MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| Vacuum | 2,0 | 8720682050590 |

E 6013 T 3,2 X 450MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| Vacuum | 2,8 | 8720682050606 |

E 6013 T 4,0 X 450MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| Vacuum | 3,0 | 8720682050613 |

E 6013 T 5,0 X 450MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| Vacuum | 2,3 | 8720682050620 |