



## Nexus E6013

### General purpose electrode for MMA welding of Mild Steel

Rutile coated all positional electrodes for the repair and joining of mild steels. Producing butts and fillet welds with a self releasing slag that is smooth and free of spatter.

#### International Standards

ISO 2560 - A - :2005	AWS A5.1-04
E 38 0 RC 11	E6013

#### Typical All-Weld Metal Analysis (wt%)

C	Si	Mn	S	P
0.07	0.40	0.50	≤ 0.025	≤ 0.025

#### Typical All-Weld Metal Mechanical Properties

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation %	Impact Strength J @ 0°C
410-470	470-550	>22	50-100

#### Welding Positions

All Positions including vertical down
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#### Materials

All mild and medium carbon steels
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#### Packaging

Size mm	2.0 x 300	2.5 x 350	3.2 x 350	4.0 x 350	5.0 x 350
Pieces/Package	200	125	75	50	35
Pieces/Carton	-	750	450	300	210
Kg/Package	1.96	2.24	2.16	2.18	2.40
Packs/Carton	-	6	6	6	6
Kg/Carton	-	13.44	12.96	13.08	14.40

#### Operating Requirements

DC+/AC (50ocv min)	50-70 A	60-100 A	80-150 A	130-200 A	150-260 A
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#### Additional Information

CE Certified	Constructional products directive (CPD)
Certification	BS EN 10204:2004 Type 2.2
Material safety data sheet	MSDS 04
Re-dry	½ - 1 Hours @ 60 - 80°C if required
Related Nexus Products	MIG Nexus SG2/SG3 TIG A15/A18