Inweld 6013

AWS A5.1 E6013

Chemical Composition of Inweld 6013

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu
Balance	0.20	0.20	0.30	0.30	1.20	1.00	---	---	0.08	---

Single values are maximum unless otherwise specified.

Description and Applications

General purpose mild steel electrode designed for thin sheet metal or light gauge steel but with sufficient penetration for welding medium gauge steels. Excellent operating characteristics when using small diameter electrodes at lower amperage and with lower open-circuit AC voltage. Used in all positions including vertical downward and overhead. This electrode is one of the easiest to use because of its wide operating range and restrike characteristics. Soft, steady, and quiet arc, low spatter and a slag that seems to peel away. This electrode gives off very little smoke or fumes - giving it superb operator appeal. Commonly used on many mild, low alloy and medium carbon steels, including tack welds on thin sheet metal, automobiles, metal furniture, farm equipment, window frames, iron grills, fences, storage tanks, and general construction.

Typical Weld Metal Properties

	AWS Spec
Tensile Strength:	60,000 psi
Yield Strength:	48,000 psi
Elongation:	17%

Recommended Parameters

SMAW (DCEP – Electrode+)

Wire Diameter	Voltage	Flat Amperage	Vertical & Overhead Welding
3/32”		60-90	50-80
1/8”		100-120	80-100
5/32”		110-160	100-150