DURAMAX®
Inspiring the future generations of welders

Product Data Sheet

DM6013 Premium Electrode

Classification: **E6013**

AWS A 5.1 / ASME SFA 5.1

DuraMax DM6013 is a LIGHT MEDIUM COATED RUTILE TYPE GENERAL PURPOSE ELECTRODE

Characteristics

The electrode is characterized by smooth and stable arc, low spatter, easy slag detachability, fine rippled bead appearance, weld deposit possesses good chemical and mechanical properties.

Typical Applications on Usage

1) Suitable for tank & vessels.
2) General fabrication.
3) Vehicles.
4) Railway wagons and machinery.
5) Ship building construction, light structural steel works
6) Storage tanks etc.

RE-DRY CONDITIONS: Re-Dry the electrode at 120°C for 30-60 minutes, for best results.

All Weld Chemical Composition (%)

C	Mn	Si	S	P	Ni	Cr	Mo	V
0.10 max	0.35 - 0.60	0.30 max	0.030 max	0.030 max	0.30 max	0.20 max	0.30 max	0.08 max

All Weld Mechanical Properties

YS (N/mm²)	UTS (N/mm²)	EL % (1=4d)	CHARPY "V" NOTCH IMPACT AT
350 - 450	450 - 540	22 - 30	0°C : 50 -80 J

Sizes available and recommended currents (DC -) or AC

SIZE	3/32	1/8	5/32
AMPS	50 ~ 80	80 ~ 120	130 ~ 170

POLARITY: DCEN or AC
DCEN: DC, Electrode Negative (straight polarity) has the least weld penetration
AC: medium weld penetration (can be more spatter)
WELDING POSITIONS: Flat, Horizontal, Overhead, Vertical-up and Vertical-down positions
USE LESS AMPS ON THIN METAL; MORE AMPS ON THICK METALS

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The above information is to be use as a guideline and is taken directly from the manufacturers Technical Data Sheet. If additional information is needed please contact (800) 692-5930