

AWS A5.1-04:  
AWS A5.1-04M:

E6013  
E4313

# BÖHLER FOX 6013

SMAW rutile electrode, carbon steel

## DESCRIPTION:

Rutile electrode with fine coating; welding in all positions and mainly with excellent welding characteristic in descending vertical position. Destined to be used in any type of steel of construction and welding in places difficult to be accessed. Practically insensitive to non-metallic impurities, rust and scale. The deposited material is characterized by its good fluidity, excellent finishing and easily removable slag.

## TYPICAL CHEMICAL COMPOSITION OF THE DEPOSITED METAL:

% Weight	%C	%Si	%Mn
	0.06	0.40	0.40

## TYPICAL MECHANICAL PROPERTIES OF THE DEPOSITED METAL:

(*)	u
Flow Limit (LE) N/mm <sup>2</sup> :	<b>330</b>
Resistance Limit (LR) N/mm <sup>2</sup> :	<b>430</b>
Stretching (S) [L <sub>0</sub> = 5d <sub>0</sub> ] %:	<b>17</b>

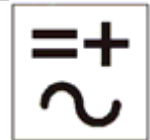
(*)	u	No treatment, as welded

## OPERATIONAL DATA:



Drying, if necessary:  
Time: 2 - 10 h  
Temperature: 300-350°C

Ømm	L (mm)	Current (A)
2.50	350	60 - 100
3.25	350	90 - 130
4.00	450	110 - 170
5.00	450	170 - 240



## BASE METALS:

Steel with up to 420 N/mm<sup>2</sup> of flow limit (60 ksi).

S235JR-E335, S235J2G3 –S355J2G3; C22, P235T1-P355T1, P235T2, P355T2, L210 –L360NB L290MB–L320MB, P235G1TH, P255G1TH, P235GH, P265GH, P295GH, S235JRS1 –S235J4S, S355G15 –355G3S, S255N –S355N, P255NH-P355NH, S255NL –S355NL, GE200-GE260, GE300.ASTM A 27 a. A36 Gr.all; A214; A242 Gr. 1-5; A266 Gr. 1, 2, 4; A283 Gr. A, B, C, D; A285 Gr. A, B, C; A299 Gr. A, B; A328; A366; A515 Gr. 60, 65; A516 Gr.55; A570 Gr.30, 33, 36, 40, 45; A572 Gr.42, 50; A606 Gr. all; A607 Gr.45; A656 Gr.50, 60; A668 Gr.A, B; A907 Gr.30, 33, 36, 40; A841;A851 Gr.1,2; A935 Gr.45; A936 Gr.50; API 5 L Gr.B, X42 –X56.

**WARNING:** The information presented herein is not a guarantee or certification for which we can be held legally responsible; this may be altered without previous notice.  
Abr/2008 Rev. 0

WELDING - 0800-119002