



**PRODUCT INFORMATION**

**SIFTRODE 6013-R**

AWS A5.1 E 6013  
EN ISO 2560 E 42 0 RC 11

**DESCRIPTION**

SIFTrode 6013-R is a versatile and general purpose rutile-coated mild steel MMA electrode which runs smoothly and leaves an attractive weld bead. SIFTrode 6013-R can be confidently used on land-based steel structures and general fabrication alike.

**WELDING POSITIONS**



Suitable for easy use in all popular welding positions, SIFTrode 6013-R offers a smooth arc, low spatter and easy-lifting slag to reveal a finely-rippled bead.

**TYPICAL WELD METAL COMPOSITION**

|    |        |
|----|--------|
| C  | 0.08 % |
| Mn | 0.60 % |
| Si | 0.40 % |

**TYPICAL MECHANICAL PROPERTIES**

|                      |                             |
|----------------------|-----------------------------|
| 0.2% Yield Strength  | ≥ 420 N/mm <sup>2</sup>     |
| Ult Tensile Strength | ≥ 500-640 N/mm <sup>2</sup> |
| Elongation           | ~ 20%                       |
| Impact Values ISO-V  | 0° ≥47J                     |

**MATERIAL TO BE WELDED**

SIFTrode 6013-R is ideal for both butt and fillet joints in a broad variety of general fabrication and repair tasks, including platework, pipe flanges, frames and tubes, as well as construction, structural steels and pressure vessels. It can be used in DC+, DC- or AC (min OCV 50V) currents/polarities, and should be re-dried at 100°C for 1hr if required.

**AVAILABLE FORMATS**

| ELECTRODE RODS (MMA / SMAW) |           |           |               |
|-----------------------------|-----------|-----------|---------------|
| Dia                         | 2.5kg Pkt | 5.0kg Pkt | Approx Pcs/KG |
| 2.0mm                       |           | RE802050  | 90            |
| 2.5mm                       |           | RE802550  | 51            |
| 3.2mm                       |           | RE803250  | 31            |
| 4.0mm                       |           | RE804050  | 20            |

| CURRENT RANGE |           |
|---------------|-----------|
| Dia (mm)      | Amps      |
| 2.0           | 30 - 50   |
| 2.5           | 55 - 85   |
| 3.2           | 90 - 135  |
| 4.0           | 130 - 170 |

For further information, contact Weldability | Sif technical support on **0870 330 7757** or email [service@wholeweld.co.uk](mailto:service@wholeweld.co.uk)



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