BÖHLER FOX OHV

Rutile-cellulosic stick electrode, unalloyed

Classification

EN ISO 2560-A	EN ISO 2560-B	AWS A5.1	AWS A5.1M
E38 0 RC 1 1	E4313 A	E6013	E4313

Characteristics and typical fields of application

Rutile-cellulosic coated electrode with good weld ability in all positions including vertical-down. Most popular E 6013 type.

For small welding machines, very good operating characteristics, flexible coating, good for tack welding. Versatile applications in structural welding, vehicle construction, boiler and tank welding, and in shipbuilding, also suitable for galvanised components.

Base materials

Steels up to a yield strength of 380 MPa (52 Ksi)

S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, ship building steels: A, B, D

ASTM A 106, Gr. A, B; A 283 Gr. A, C; A 285 Gr. A, B, C; A 501, Gr. B; A 573, Gr. 58, 65; A 633, Gr. A, C; A 711 Gr. 1013; API 5 L Gr. B, X42, X52

Typical analysis of all-weld metal

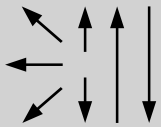
	C	Si	Mn
wt.-%	0.06	0.4	0.45

Mechanical properties of all-weld metal – typical values (min. values)

Condition	Yield strength R_e	Tensile strength R_m	Elongation A (L_0=5d_0)	Impact work ISO-V KV J		
	MPa	MPa	%	+20 °C	±0 °C	–10 °C
u	**460** (≥ 380)	**490** (470 – 600)	**25** (≥ 20)	**75**	**60** (≥ 47)	**47**

u untreated, as welded

Operating data



Polarity:	Redrying	Electrode identification:	ø (mm)	L mm	Amps A
DC (–)	not necessary	FOX OHV 6013	2.0	250	45 – 80
AC		E 38 0 RC	2.5	250/350	60 – 100
			3.2	350	90 – 130
			4.0	350/450	110 – 170
			5.0	450	170 – 240

Approvals

TÜV (05687.), DB (10.014.12), ABS, DNV GL, LR, CE