



Unibraze 6013 (E6013)

Unibraze 6013 is an all-purpose electrode that can be used with either AC or DC operation. Originally developed for light gage metal, it offers sufficient penetration for welding on heavier assemblies. Ideal for general purpose fabrication, machine parts, metal buildings and structures, and shaft build-up.

Features

- All position
- Slag removes easily
- Excellent arc stability
- Fast-freeze

Benefits

- Welds in flat, horizontal, vertical, and overhead positions
- Quick clean-up
- Welding accuracy and efficiency
- Excellent for poor fit-up

Typical Weld Metal Chemistry

Carbon	.10
Manganese	.28
Silicon	.27
Phosphorus	.012
Sulphur	.016

Typical Mechanical Properties

Tensile Strength	72,600 psi (501 MPa)
Yield Strength	61,300 psi (423 MPa)
Elongation	26.5%
Reduction of Area	25% to 55%

Recommended Operating Parameters

Dia.	Type of Power	Optimum Amps
3/32"	AC, DCEN or DCEP	70
1/8"	AC, DCEN or DCEP	100
5/32"	AC, DCEN or DCEP	150
3/16"	AC, DCEN or DCEP	190

For out of position welding, reduce amperages shown by 15%.

Specifications

AWS A5.1 ASME SFA5.1 Class E6013

Standard Sizes

3/32" (2.4mm), 1/8" (3.2mm), 5/32" (4.0mm), 3/16" (5.0mm)

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