



## Covered Electrode Carbon Steel

### HM 28

Classifications: **AWS A5.1:2012 E6013 ASME SFA5.1 E6013**

E6013- Carbon Steel Electrode with Rutile Coating

**Designed for welding all types of joints, even without preparation, in any position. It is suitable for metal structures, galvanized sheets, and general constructions, featuring a stable arc, low spatter, and easy slag removal, which enhances work productivity. Additionally, it produces beads with an excellent finish. Its ease of arc opening and reignition makes it an excellent electrode for tacking. It has low fume emission and very satisfactory performance, making it a reliable choice for various types of welding.**

#### ALLOY TYPE:

C 0,20% Máx.	Mn 1,20% Máx.	Si 1,00% Máx.	P N. E.	S N. E.	Ni 0,30% Máx.	Mo 0,30% Máx.	V 0,080% Máx	Cr 0,20% Máx.
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#### MECHANICAL PROPERTIES:

TENSILE STRENGTH:	YIELD STRENGTH:	ELONGATION:	IMPACT RESISTANCE:
430 MPa (Min.)	330 MPa (Min.)	17 % (Min.)	

<b>WELDING CURRENT:</b>	CC+; CC-; CA
<b>TYPE OF COATING:</b>	RUTÍLICO



Flat



Horizontal



Vertical



Overhead

#### PRODUCT CHARACTERISTICS:

DIAMETER (mm):	LENGTH (mm):	AMPERAGE (A):	PACKAGING (kg):
2,00	350	45 a 80	15,00
2,50	350	70 a 100	20,00
3,25	350	90 a 130	20,00
4,00	350	130 a 170	20,00

#### CUSTOMER SERVICE POLICY

The above information is for reference purposes only, it should not be considered as a guarantee or certificate. Many variables can influence the results of a welding operation. Uniweld Industria de Eletrodos LTDA is not responsible for any incorrect application of the product, We recommend that, if you have any questions, you contact our Technical Assistance department to Oget adequate support.