

# NOUVE® 6013

## Designation

**AWS/SFA-5.1: E6013**  
**UNS No. W06013**

## Welding Positions



### Features

- ▶ Excellent arc characteristics
- ▶ Low moisture re-absorption
- ▶ Low spatter level
- ▶ Low smoke level
- ▶ Quick and easy slag removal
- ▶ Radiography quality

### Applications

Welding of all types of mild steel structures, tanks and vessels, pipe lines, railway wagons, bridges, ship hull, boilers etc.

### Type of Current

Direct Current Electrode Negative (DCEN)  
 and Alternate Current (AC)

### Recommended Welding Techniques

GENERAL : AC and DCEN  
 ARC LENGTH : Short arc

### Weld Metal Chemistry

WELD METAL ANALYSIS (%)	AWS SPEC	TYPICAL
Carbon (C)	0.20 max	0.065
Manganese (Mn)	1.20 max	0.48
Silicon (Si)	1.00 max	0.22
Phosphorous (P)	Not Specified	0.018
Sulphur (S)	Not Specified	0.016

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## Mechanical Properties (as welded)

MECHANICAL TESTS	AWS SPEC		TYPICAL		
Tensile Strength	62,367 psi (430 MPa) Minimum		69,618 psi (470 MPa)		
Yield Strength	47,863 psi (330 MPa) Minimum		63,817 psi (360 Mpa)		
Elongation % in 2"	17% Minimum		Above 23%		
Impact Energy (min)	Single Value	24J at -30°C	Single Value	At 0°C	68
	Average Value	26J at -30°C	Average Value		65

## Dimension, Current Condition & Packing Data

DIAMETER (IN)	DIAMETER (MM)	PACKAGE		CURRENT CONDITION (AC) Amps
		INNER	OUTER	
3/32	2.5	2.5 Kg	20 Kg	60 - 90
1/8	3.15	2.5 Kg	20 Kg	80 - 110
5/32	4.0	2.5 Kg	21 Kg	110 - 150
3/16	5.0	2.5 Kg	21 Kg	150 - 180