XTR Select 6013

A5.1 E6013

Features & Applications:

XTR Select is the most versatile all-around repair and fabrication of clean, well-fitting common mild steel components. Fast freeze slag characteristics ensures fully positional operability.

- Only mild steel electrode offering the convenience of flat , vertical up and down, and overhead without changing amperage setting
- Electrode can be bent without flux breakage
- Contact (drag) type transfer allows the electrode to weld by itself

Chemistry:

	Typical	AWS Spec. Single values are max.
Carbon (C)	0.080	0.200
Manganese (Mn)	0.500	1.200
Silicon (Si)	0.200	1.000
Nickel (Ni)	0.300	0.300
Chromium (Cr)	0.200	0.200
Molybdenum (Mo)	0.300	0.300
Vanadium (V)	0.080	0.080
Sulfur (S)	0.010	ns
Phosphorus (P)	0.020	ns

Mechanical Properties: (All weld metal analysis, Typical Weight %)

	Typical	AWS Spec. Single values are min.
Tensile Strength	83,000	60,000 psi
Yield Strength	75,000	48,000 psi
Elongation in 2" (%)	25	22
Charpy V-Notch	90J: -20°C	15 ft-lbs. @ -20°F
Diffusible Hydrogen (mL/100g weld metal)	nr	nr

Coating	High Titania Potassium
Flux Coating, Color	Tan

Welding Positions:

F, V, OH, H

Operating Parameters: Coated Electrode/Rod (SMAW), DC Straight (-), Reverse (+) or AC

Formula: 1160

Procedures & results may vary with any change in position, equipment being used, base metal and base metal cleanliness.

Diameter	Amperage Range	Weldmetal Electrode	Electrodes per lb. (kg) of Weldmetal	Arc Time of Deposition min/lb. (kg)	Electrodes (Rods) per Lb. Packaged
1/16 **(1.6mm)**	20-40	.11oz (3g)	145 (320)	57 (125)	60
5/64 **(2.0mm)**	30-50	.14oz (4g)	114 (251)	47 (103)	42
3/32 **(2.4mm)**	50-70	.30oz (8g)	53 (117)	36 (79)	25
1/8 **(3.2mm)**	70-110	.62oz (17g)	26 (57)	25 (55)	15
5/32 **(4.0mm)**	115-140	1oz (28g)	16 (35)	20 (44)	10
3/16 **(4.8mm)**	150-200	1.5oz (42g)	11 (23)	14 (31)	7
1/4 (6.4mm)	nr	--	--	--	--

SCAN for SDS

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