

MG E6013



**All-purpose electrode for mild steel,
excellent for light gauge work, all position**

GENERAL CHARACTERISTICS:

For all types of mild steel fabrication. Ideal for light gauge work. Best electrode available for vertical and overhead welding.

APPLICATIONS:

Use for general production and repair work. Generally used for thin sections and sheet metal. For farm, industrial, and construction where light fabrication and repair work is performed and places where repair work is performed on a regular basis.

TECHNICAL DATA:

Typical Tensile Strength	Up to 80,000 psi (552 N/mm ²)
Typical Yield Strength	Up to 67,000 psi (462 N/mm ²)
Elongation	Approx. 24%
Current	AC or DC either polarity

Diameter	Amperage
3/32" (2.4mm)	30-80
1/8" (3.2mm)	80-120
5/32" (4.0mm)	120-190

PROCEDURE:

Joints should be as clean as possible and close fitting. Use DC straight polarity for shallow penetration. DC reverse polarity will give deeper penetration. Excellent for use with low open circuit voltage AC welders. Tip the electrode slightly in the direction of travel. Maintain a close arc gap and use either stringer beads or slight weave. Slag is virtually self releasing.

