

**FINE BOND (E 6013)**AWS : A 5.1, E 6013  
IS : 814 ER 4222**APPLICATIONS :-**

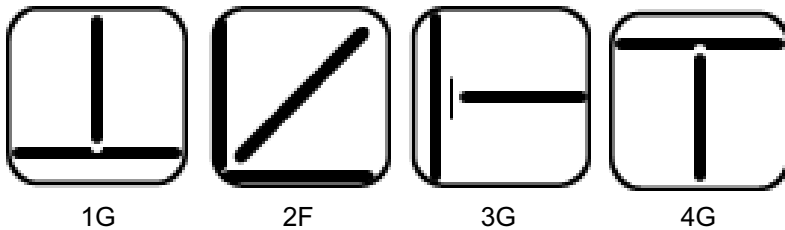
Structures & Building Construction Auto Bodies And Railway Wagons Grills, General Fabrication Vessels, Tanks, Pipelines, Bridges, Ships, Traile

**CHARACTERISTICS ON USAGE :-**

A medium coated all position electrode for work of structural importance with medium penetration, soft arc and low spatter, easy to detach slag. It can be used in both AC & DC.

**NOTES ON USAGE :-**

- 1) Dry electrode at 70-100 °C for 30-60 min.before use.
- 2) Pay attention not to exceeds the range of proper current.

**WELDING POSITIONS :-****CHEMICAL COMPOSITION OF WELD METAL**

C%	Mn%	Si%	S%	P%
0.20 Max	1.20 Max	1.0 Max	0.040 Max	0.040 Max

**MECHANICAL PROPERTIES OF WELD METAL**

U.T.S. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 5d )	IMPACT(CVN) AT 0° C
450 min	350 min	22 % Min	47 Joules Min

**PACKING AND WELDING CURRENT**

ITEMS	SIZE	PKT/BOX	PCS/PKT	PCS/BOX
<b>FINE BOND E 6013</b>				
FINE BOND	2.50 X 350 M.M.	8	125	1000
FINE BOND	3.15 X 450 M.M.	8	90	720
FINE BOND	4.00 X 450 M.M.	8	60	480
FINE BOND	5.00 X 450 M.M.	8	35	280