

FINE - S (E 6013)AWS : A 5.1, E 6013
IS : 814 ER 4212 X**APPLICATIONS :-**

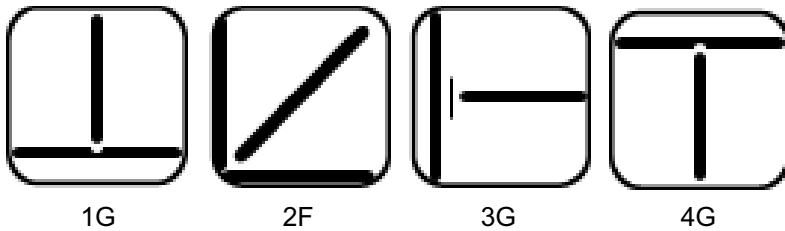
Ship Building Storage Tanks & Boilers Pressure Pipes Railway Coach

CHARACTERISTICS ON USAGE :-

A medium coated rutile type all position electrode with excellent welding characteristics for major structural works where finishing is of importance . Low spatter , smooth arc and easy slag removal, easy to operate in vertical upward position. Ideal where radiographic quality is required

NOTES ON USAGE :-

- 1) In case of varticle download welding, manipulate the electrode, keeping its tip in contact with base metal.
- 2) Dry the electrode at 70-100 °C for 30-60 min. before use

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

C%	Mn%	Si%	S%	P%
0.12 Max	0.65 Max	0.40 Max	0.04 Max	0.04 Max

MECHANICAL PROPERTIES OF WELD METAL

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 5d)	IMPACT (CVN) AT 0° C	RADIOGRPHY TEST in 100 gm Weld Metal
460 - 560	370 – 480	22 % Min	47 Joules Min	Satisfactory as per IIW blue std

PACKING AND WELDING CURRENT

ITEMS	SIZE	PKT/BOX	PCS/PKT	PCS/BOX
FINE S E 6013				
FINE S	2.50 X 350 M.M.	4	225	900
FINE S	3.15 X 350 M.M.	4	130	520
FINE S	3.15 X 450 M.M.	4	130	520
FINE S	4.00 X 450 M.M.	4	85	340
FINE S	5.00 X 450 M.M.	4	55	220