FINE - SS (E 6013)

AWS : A 5.1, E 6013 IS : 814 EC 4221 X

APPLICATIONS:-

Ship Building Storage Tanks & Boilers Pressure Pipes Railway Coaches

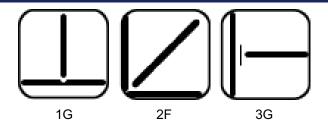
CHARACTERISTICS ON USAGE:-

A heavy coated rutile type electrodes 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 fillet welding. Ideal where radiographic quality is required.

NOTES ON USAGE:-

- 1) In case of varticle download welding, manipulate the electrode, keeping its tip in contanct 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	0.040 Max	0.040 Max

MECHANICAL PROPERTIES OF WELD METAL

U.T.S.	Y.S.	ELONGATION	IMPACT(CVN)	RADIOGRPHY TEST
(N/mm²)	(N/mm²)	(L = 5d)	AT 0° C	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 - SS (E 6013)								
FINE SS	2.50 X 350 M.M.	4	175	700					
FINE SS	3.15 X 450 M.M.	4	105	420					
FINE SS	4.00 X 450 M.M.	4	65	260					
FINE SS	5.00 X 450 M.M.	4	40	160					