

**FINE - SS (E 6013)**AWS : A 5.1, E 6013  
IS : 814 EC 4221 X**APPLICATIONS :-**

Ship Building Storage Tanks &amp; 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 contact with base metal.
- 2) Dry the electrode at 70-100 °C for 30-60 min.before use.

**WELDING POSITIONS :-**

1G

2F

3G

**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. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	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
<b>FINE - SS (E 6013)</b>				
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