



SUNWELD 6013

CLASSIFICATION:

A5.1: E 6013
IS: 814 ER 4211X

DESCRIPTION:

SUNWELD 6013 is a medium coated all position mild steel electrode for use in steel fabrication with excellent mechanical properties even at low current. Deep penetration, low spatter, easy detachable slag, sound arc, smooth bead are the main features of this electrode.

APPROVALS:

BIS, BHEL-TRICHY, PDIL, IRS GRADE 2

TYPICAL ALL WELD METAL PROPERTIES:

| Chemical Composition (%) | | | | Mechanical Properties | |
|--------------------------|----------|----|----------|-----------------------|--------------------------|
| C | 0.10 max | Mn | 0.50 | YS | 40-45 Kg/mm ² |
| Si | 0.30 max | S | 0.03 max | UTS | 46-51 Kg/mm ² |
| P | 0.04 max | | | EL (L=5d) | 22-30% |
| | | | | Impact (CVN) at 0°C | 49-80 Joules |

TYPICAL APPLICATIONS:

Mild Steel Structures, rail coaches, wagons, storage tanks, ships, sheet metal work, dredgers, trawlers etc.

CURRENT RANGE & PACKING DATA:

| Size | Length | Current Range | Quantity of Electrodes | Quantity of Electrodes in a |
|------|--------|---------------|------------------------|-----------------------------|
| (mm) | (mm) | (Amps) | In a Carton | Cardboard Box |
| 2.5 | 350 | 60-90 | 135 | 810 |
| 3.15 | 350 | 100-135 | 90 | 540 |
| 3.15 | 450 | 100-135 | 90 | 540 |
| 4 | 450 | 140-190 | 60 | 360 |
| 5 | 450 | 200-260 | 35 | 210 |

PACKING:

Electrodes are packed in Cartons and Six of these Cartons are shrink wrapped in a cardboard box.