

SUNWELD 6013

Mild Steel Electrode



CLASSIFICATION

IS 814-04 : ER 4211X
AWS/A 5.1 : E 6013
Approval : BIS, IBR, IRS

CHARACTERISTICS

SUNWELD 6013 is a medium coated rutile type all position mild steel electrode suitable 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 some special features of this electrode.

APPLICATIONS

Mild Steel Structure, Rail Coaches, Wagons, Storage Tanks, Ships, Sheet Metal, redgers, Auto parts etc.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

Carbon	Manganese	Silicon	Sulphur	Phosphorus
0.075	0.46	0.19	0.019	0.019

MECHANICAL PROPERTIES OF ALL WELD METAL (TYPICAL) (AS PER IS 814-04)

Yield Strength	Ultimate Tensile Strength	Elongation (GL=5d)	Reduction in Area	Impact (CVN) at 0° C
401.0 N/mm ²	499.0 N/mm ²	26.00%	64.20%	72 Joules avg

PACKING DATA:

Size (mm)	Length (mm)	Current (Amp) AC OVC 50 or DC (+/-)	Quantity of Electrodes in a Carton	Quantity of Electrodes in a Cardboard Box
125 X 8	350	60-90	5 Kg	20 Kg
3.15	350/450	100-135	5 Kg	20 Kg
4.00	350/450	140-190	5 Kg	28 Kg
40 X 8	350/450	190-220	5 Kg	28 Kg

RECOMMENDATIONS:

It is always better to re-dry the electrodes at 100°C for 30 minutes to obtain the best results. Use current within recommended range.