

ROYAL – S (E 6013)

AWS: A 5.1, E 6013 | IS: 814 ER 4212 X EN ISO 2560 A E 38 0 RR 12

Applications

Ship Building Storage Tanks & Boilers Pressure Pipes Railway Coaches

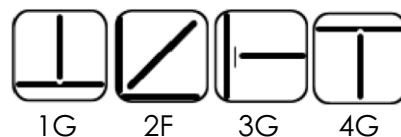
Characteristics on Usage

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

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

Welding Positions



Approvals

I.R.S, L.R.S, I.B.R, B.V, D.N.V,
P.D.I.L, B.I.S [ISI], TOYO[TEIL],
THERMAX,L & T A.B.S, K.N.P.C.,
K.P.G. I.L.I.O.C.L,M.R.P.L, TPL
UHDE INDIA LTD., M.M.D.,
B.H.P.V.,NPCIL, RDSO CLASS
A2,

MILD STEEL ELECTRODES

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
460 - 560	370 – 480	22 % Min	47 Joules Min	Satisfactory as per IIW blue std

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	LBS PER PACKET	LBS PER CARTON	In Amps	Current (Amps)
2.50 X 350	5	20	11	44	60-90	AC / DC (-)
3.20 X 350/450	5	20	11	44	100-140	
4.00 X 350/450	5	20	11	44	140-190	
5.00 X 350/450	5	20	11	44	190-250	