

ROYAL – SS (E 6013)

AWS: A 5.1, E 6013 | IS: 814 ERR 4222 X EN ISO 2560 A E 38 0 RR 12

Applications

Used for Bridges & Boilers, Compressors, Automobile parts, Fine steel furnitures, Railway coaches, Locomotive fireboxes & Scooter frames.

Characteristics on Usage

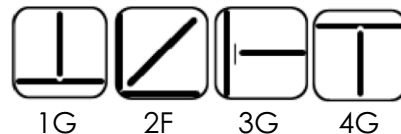
A heavy coated all position electrode for major or minor structural work. The weld metal is radiographic quality, smooth arc, low spatter and medium penetration.

Notes On Usage

⚠ In case of varticle download welding manipulate the electrode keeping its tip in contact with base metal.

⚠ Dry the electrode at 70-100 °C for 30-60 min. before use.

Welding Positions



Approvals

B.V.

MILD STEEL ELECTRODES

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%
0.12 Max	0.75 Max	0.50Max	0.030 Max	0.030 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
400 - 560 Min	330 Min	22 % Min	47 Joules Min	Satisfactory

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	