

SUNSPEED 6013

Mild Steel Electrode



CLASSIFICATION

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

CHARACTERISTICS

SUNSPEED 6013 is a rutile type medium coated all position welding electrode. It has a stable forceful arc which is easy to strike and restrike. Stable and smooth arc, low spatter, easily detachable slag, smooth well rippled shining beads are the salient features of this electrodes.

APPLICATIONS

Tanks, Ships, Boilers, Trawlers, Dredgers, Machinery Construction, Rail Coaches & Wagons, Bridges, Auto parts etc.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

Carbon	Manganese	Silicon	Sulphur	Phosphorus
0.072	0.42	0.19	0.017	0.018

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
392.0 N/mm ²	492.0 N/mm ²	26%	64.20%	70 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
2.50	350	60-90	2.5 Kg	20 Kg
3.15	350/450	100-135	2.5 Kg	20 Kg
4.00	450	140-190	2.5 Kg	20 Kg
5.00	450	190-220	2.5 Kg	20 Kg

RECOMMENDATIONS:

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