

SUNWELD S 6013

Mild Steel Electrode



CLASSIFICATION

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

CHARACTERISTICS

SUNWELD S is rutile type medium heavy coated electrode specially designed for radiographic quality welds. Easy slag removal and finely rippled smooth beads are the some special features of this electrode.

APPLICATIONS

Ship construction, Tanks, Barges, Dredgers, Structures, Boilers & Pressure Vessels, Bogies & under frame of railway carriages and Wagons, bridges & Dam construction, Cranes, Machine building, Plate and Metal sheet fabrication etc.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

Carbon	Manganese	Silicon	Sulphur	Phosphorus
0.075	0.45	0.20	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
403.0 N/mm ²	501.0 N/mm ²	26%	68.20%	74 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	5 Kg	20 Kg
3.15	350/450	100-135	5 Kg	20 Kg
4.00	350/450	140-190	5 Kg	20 Kg
5.00	350/450	190-220	5 Kg	20 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.