

SUNWELD SS 6013

Mild Steel Electrode



CLASSIFICATION

IS 814-04 : ERR 4222X
AWS/A 5.1 : E 6013
Approval : IBR

CHARACTERISTICS

SUNWELD SS is a heavy coated rutile type electrode of excellent performance characteristics for welding of mild steel, structure steel, pressure vessels and for ship plates. It has very good slag detachability and shiny bead appearance. Welds are of radiographic quality and gives excellent mechanical properties.

APPLICATIONS

Boilers & Pressure Vessels, Ship building, storage tanks, Hull construction, Storage tanks, Wagons, Automobile frames and bodies, Rolling stocks, Train coaches, Locomotive fireboxes etc.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

Carbon	Manganese	Silicon	Sulphur	Phosphorus
0.074	0.46	0.20	0.018	0.020

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%	67.60%	76 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 redry the electrodes at 100°C for 30 minutes to obtain the best results. Use current within recommended range.