

ROYAL BOND (E 6013)

AWS: A 5.1, E 6013 | IS: 814 ERR 4222 EN ISO 2560 A E 38 0 R 11

Applications

Structures & Building Construction Auto Bodies And Railway Wagons Grills, General Fabrication Vessels, Tanks, Pipelines, Bridges, Ships, Trailers.

Characteristics on Usage

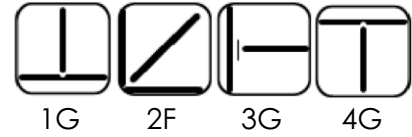
A medium coated all position electrode for work of structural importance with medium penetration, soft arc and low spatter, easy to detach slag. It can be used in both AC & DC.

Notes On Usage

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

⚠ Pay attention not to exceeds the range of proper current.

Welding Positions



Approvals

I.R.S, I.B.R, L & T, A.P.G.L.B.I.S [ISI], IOCL, TPL

MILD STEEL ELECTRODES

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%
0.20 Max	1.20 Max	1.0 Max	0.040 Max	0.040Max

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	IMPACT (CVN) AT 0° C
450 Min	350 Min	22 % Min	47 Joules Min

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	2.5	25	AC / DC (-)	60 - 90
3.15 x 350	2.5	25		100 - 140
4.00 x 450	2.5	25		140 - 180
5.00 x 450	2.5	25		180 - 230