



RASI E 6013R

GENERAL PURPOSE MILD STEEL
WELDING ELECTRODES

TECHNICAL SPECIFICATION SHEET

CHARACTERISTICS

RASI E 6013 R is an all position medium heavy coated mild steel electrode of outstanding quality permitting use of Low open circuit Voltage, Excellent welding performance and mechanical properties with Radiographic Soundness are easily achievable.

APPLICATIONS

RASI E 6013 R is suitable for all types of mild steel structurals, Plant machinery pipes, dredgers & Trailer's etc.

CLASSIFICATIONS

IS : 814 : ER 4224X
AWS : A 5.1: E - 6013

CHEMICAL COMPOSITION OF ALL WELD METAL

| | |
|--------------------------|-----------------|
| Carbon - 0.12% | Silicon - 0.30% |
| Manganese - 0.40 - 0.60% | Sulfur - 0.03% |
| Phosphorus - 0.03% | |

Note: Single Values shown above are maximum

MECHANICAL PROPERTIES OF ALL WELD METAL

Tensile Strength (N/mm²) - 410 - 510
Yeild Strength (N/mm²) - 330 MIN.
Elongation (L-5d) % - 22 MIN.
CVN IMPACT @ 0°C - 47 J MIN

WELDING CURRENT : DC± / AC 50 V

Ø 2.00 mm - 40-60 Amps | Ø 2.50 mm - 60-90 Amps
Ø 3.15 mm - 100-140 Amps | Ø 4.00 mm - 140-190 Amps
Ø 5.00 mm - 180-240 Amps.

***FOR APPROVALS AND CERTIFICATIONS KINDLY CONTACT :- info@rasielectrodes.com**

storage - Store in warm and dry place. If damped re dry at 100-110°C for 30 minutes.

*All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied.

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