



RASI E 8013 G

premium

BASIC COATED LOW HYDROGEN
ELECTRODES

TECHNICAL SPECIFICATION SHEET

CHARACTERISTICS

RASI E 8013 G is a Heavy coated rutile type all position electrode giving Low alloy Steel Weld Metal with 1 Chrome, 1/2 Moly, 0.2 Vanadium ideally suitable for welding of steels of similar compositions. The welds are Radio graphically sound and creep Resistance up to 550°C

APPLICATIONS

Boilers, pressure vessels, Rigid structures, Components under dynamic loading ship building, Heavy sections, Carbon steels, free cutting steels, Penstocks, Blast Furnace Shells, Rail Wagons and Coaches.

CLASSIFICATIONS

AWS- A 5.5 : E 8013 G

CHEMICAL COMPOSITION OF ALL WELD METAL

Carbon - 0.08%	Silicon - 0.30%
Manganese - 0.58%	Sulfur - 0.03%
Phosphorus - 0.03%	Cr - 1.25%
Mo - 0.55%	V - 0.25%

Note: Single Values shown above are maximum

MECHANICAL PROPERTIES OF ALL WELD METAL

Tensile Strength (N/mm²) - 580
Yeild Strength (N/mm²) - 530
Elongation % - 25% MIN.

WELDING CURRENT : DC± / AC 50 V

Ø 2.50 mm - 60 - 100 Amps
Ø 3.15 mm - 100 - 140 Amps
Ø 4.00 mm - 140 - 190 Amps
Ø 5.00 mm - 190 - 240 Amps.
Ø 6.30 mm - 240 - 300 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.

www.rasielectrodes.com

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