



GOLD-WELD E 6013

GENERAL PURPOSE MILD STEEL
WELDING ELECTRODES

TECHNICAL SPECIFICATION SHEET

CHARACTERISTICS

GOLD-WELD E 6013 is a medium coated rutile type all position general purpose mild steel electrode. It gives a quite and stable arc, steady fusion rate, least spatter and smooth weld bead with radiographic quality. Easy removal of slag and excellent weld quality facilitate multi pass welding.

APPLICATIONS

Suitable for welding OF GENERAL FABRICATIONS , tanks and vessels, steel frames, steel furniture, steel structurals, etc.

CLASSIFICATIONS

IS. 814 ER 4211X
AWS : A5.1 E-6013

CHEMICAL COMPOSITION OF ALL WELD METAL

Carbon - 0.12%	Silicon - 0.30%
Manganese - 0.60%	Sulfur - 0.012%
Phosphorus - 0.014%	Iron - Balance

Note: Single Values shown above are maximum

MECHANICAL PROPERTIES OF ALL WELD METAL

Tensile Strength (N/mm²) - 410 - 510
Yield 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 dampened 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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