



RASI E 6013

premium product

GENERAL PURPOSE MILD STEEL
WELDING ELECTRODES

TECHNICAL SPECIFICATION SHEET

CHARACTERISTICS

RASI E6013 is a general purpose, all position steel electrode for welding of mild steels such as; vehicles, ship building/repair, sheet metal, piping, pressure vessel fitting, boilers, galvanized steel, and general light fabrication. The coating produces a forceful, spray type arc resulting in excellent mechanical properties which operates with AC or DCEP.

APPLICATIONS

RASI E-6013 is ideally designed for welding structural steel works like column, trusses, grills, Bus & Truck body building and plant equipments.

CLASSIFICATIONS

ANSI/AWS A5.1 & ASME SFA 5.1 E6013
IS : 814 ER 4221 X

CHEMICAL COMPOSITION OF ALL WELD METAL

Carbon - 0.12%	Silicon - 0.3%
Manganese - 0.60%	Sulfur - 0.03%
Phosphorus - 0.03%	Iron - Balance

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.

www.rasielectrodes.com

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