



## RASI E 6013RR

premium product

GENERAL PURPOSE MILD STEEL  
WELDING ELECTRODES

### TECHNICAL SPECIFICATION SHEET

#### CHARACTERISTICS

RASI E 6013 RR is a heavy coated rutile type electrode of exceptionally good running characteristics for achieving Radiographic quality it welds smooth arc, medium penetration and negligible spatter.

#### APPLICATIONS

It is recommended in applicants such as , bogies under frames of railway carriages, wagons, boilers, pressure vessels, general engineering constructions, Pipe Welding, ship building, truck, bus frames and bodies etc.

#### CLASSIFICATIONS

IS. : 814 ERR 4224X

AWS : A5.1 E-6013

#### 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/mm<sup>2</sup>) - 410 - 510  
 Yeild Strength (N/mm<sup>2</sup>) - 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](mailto: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](http://www.rasielectrodes.com)

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