

Ratna E 6013

CLASSIFICATION

- AWS/SFA 5.1 E 6013
- BS 639 E4322R21
- IS-814 ER 4222
- DIN 1913 E 4322R322

APPLICATIONS

- Suitable for tank & vessels.
- General fabrication.
- Ship building construction, light structural steel works.
- Railway wagons and machinery.
- Vehicles.
- Storage tanks etc.

DESCRIPTION

- The electrode is characterized by smooth and stable arc, low spatter, easy slag detachability, fine rippled bead appearance, weld deposit possesses good chemical and mechanical properties.

TYPICAL WELD METAL CHEMICAL PROPERTIES (ELEMENT %)

CARBON (C)	MAGNESIUM (MN)	SILICON (SI)	SULFUR (S)	PHOSPHORUS (P)
0.65 MAX	0.41	0.24 MAX	0.011 MAX	0.021 MAX

CURRENT POLARITY

DC(-), AC

WELDING POSITION

FLAT, HORIZONTAL, VERTICAL, OVERHEAD

TYPICAL WELD METAL MECHANICAL PROPERTIES (ELEMENT %)

YIELD STRENGTH (N/MM ²) KSI	ULTIMATE TENSILE STRENGTH (N/MM ²) KSI	ELONGATION (%)	CVN IMPACT AT °C JOULES
425 (62)	490 (71)	26	0°C : 62 J

SIZE AND CURRENT RECOMMENDATIONS

SIZE D X L (MM)	SIZE D X L (IN)	CURRENT (AMPS) DC-, AC
2.5mm x 350mm	3/32" x 14"	50-80
3.2mm x 350mm	1/8" x 14"	80-130
4.0mm x 350mm	5/32" x 14"	130-170

RE-DRY CONDITIONS

- Re-dry the electrode at 120°C for 30-60 minutes, for best results.

NOTE:

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