

SME 6013

Stick Electrodes (SMAW)

Mild Steel

Classifications:

AWS A/SFA 5.1 : E 6013
 IS 814 : ER 4212 X
 Coating Type : Rutile
 Coating Factor : Medium
 Identification : Brand Printed

Characteristics:

An electrode for structural applications. It gives good arc stability, fine ripples and easy slag removal. It can be used in all positions, especially in vertical down. It gives X-ray quality welds.

Applications:

1. Joining steels like A, B, C, D, grades of ASTM SA-283
2. Steel structures and tanks
3. Truck frames and bodies
4. Ships
5. Pipelines, bridges and others



Weld Metal Chemistry (wt%):

C	Mn	Si	S	P
0.10 max	0.5	0.4	0.01	0.01

Mechanical Properties of All Weld Metals:

Condition	UTS, MPa	YS Mpa	EL% (L=4Xd)	CVN Impact, J 0°C
As-welded	460-550	370-480	22-28	50 min.

Wedling Positions :

F, H, V-down, V-up, OH

Redrying Positions :

Moist electrodes may be reconditioned at 100 - 110°C for 1/2 hr

Availability :

Standard Size : 5.0, 4.0, 3.2 and 2.5 in 350/450 mm length
 Packing : 350 & 450 mm in 1, 2 & 5 kg.

Options Available : SME 6013 S , SME 6013 SS