

RATNA- 6013X

Medium heavy coated rutile type all position welding Electrode for Carbon steel.

CLASSIFICATION : AWS/SFA-5.1: E 6013 , BS 639 E4322R21
IS-814: ER 4222 X , DIN 1913 E 4322R3

APPROVAL : BIS, CIB, ABS, IRS, BV, BAX, PDIL , Toyo, BHEL

CHARACTERISTICS : A medium heavy coated rutile type all position welding electrode with weld deposit of radiographic quality. The electrode can be subjected to low OCV, offer smooth rippled bead appearance coupled with low spatter and fumes.

APPLICATION :

- 1) Suitable for storage tanks.
- 2) Rail coaches.
- 3) Pressure vessels.
- 4) Heavy structures.
- 5) Ship construction
- 6) Structure works, Boilers etc.

RE-DRY CONDITION : Re-Dry the electrode at 120°C for 30-60 minutes, for best results.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S	P
0.10 max.	0.40-0.60	0.30 Max	0.030 Max	0.030 Max

ALL WELD MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT
350-470	450-540	22-30	0°C : 50-80 J

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (DXL)	Size(inch) (DXL)	Current Condition (DC-/AC) Amps	No. of Pcs./pkt.	No. of Pcs./Case
2.00 X 300	5/ 64" X 12"	50-75	335	1340
2.50/ 2.40 X 350	3/ 32" X 14"	60-90	270	1080
3.15/ 3.20 X 350/ 450	1/ 8" X 14/18"	100-130	160/155	640/620
4.00 X 350/ 450	5/ 32" X 14/ 18"	150-180	100	400
5.00 X 450	3/ 16" X 18"	190-230	62	248

Customer packing on request.