

# RATNA-6013XX

## Heavy coated rutile type all position welding Electrode for structural steel welding.

**CLASSIFICATION** : AWS/SFA-5.1: E 6013 , BS 639 E 4322RR21  
IS-814: ERR 4222 X , DIN 1913 E 4322RR622

**APPROVAL** : BIS

**CHARACTERISTICS** : An all position, heavy coated, radiographic electrode with exotic finish weld deposit. Weld bead is smooth and shiny. Electrode is designed to achieve high welding efficiency and gives excellent mechanical and chemical properties coupled with property of auto slag removal.

**APPLICATION** :

- 1) Suitable for boilers.
- 2) Heavy section.
- 3) Ship hull construction and repair & maintenance of pressure vessel.
- 4) Structural works.
- 5) Rail coaches/ wagons.
- 6) Locomotive fire boxes, coach panel & bridging wide root gap.

**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 <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT
350-460	440-540	22-32	0 <sup>0</sup> 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
2.50/ 2.40 X 350	3/ 32" X 14"	60-90	205	800
3.15/ 3.20 X 450	1/ 8" X 18"	90-130	125	500
4.00 X 450	5/ 32" X 18"	140-180	80	300
5.00 X 450	3/ 16" X 18"	180-210	50	220

Customer packing on request.