

# RATNA 6013

## Light medium coated rutile type General purpose all position welding Electrode

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

**APPROVAL** : BIS, DNV, IRS

**CHARACTERISTICS** : 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.

**APPLICATION** :

- 1) Suitable for tank & vessels.
- 2) General fabrication.
- 3) Vehicles.
- 4) Railway wagons and machinery.
- 5) Ship building construction, light structural steel works
- 6) Storage tanks 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.	0.35-0.60	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
350-450	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
2.50/ 2.40 X 350	3/ 32" X 14"	50-80	270	1080
3.15/ 3.20 X 350/ 450	1/ 8" X 14/ 18"	80-120	175	700
4.00 X 450	5/ 32" X 18"	130-170	105	420
5.00 X 450	3/ 16" X 18"	190-220	68	272
6.30 X 450	15/ 64" X 18"	220-270	35	140

Customer packing on request.