

TECHNICAL DATA SHEET

BRAND NAME: HIGH TIDE E6013

Classification:

AWS A /SFA 5.1 E 6013

IS 814:2004 ER 4211

RDSO CLASS A2,

Approval:

DESCRIPTION AND APPLICATIONS:

It is medium coated all position rutile type electrode. It is suitable for light and medium structural works. The weld deposit is consistent in mechanical and radiographic quality. The slag is easy to remove. The electrodes weld with least amount of spatter and smoke.

Typical applications:

- General fabrication vessels, tanks in steel plant
- Bridge, structure and construction work
- Automobile frames & bodies
- Shipbuilding & pipelines
- Storage tank & Furniture work
- Joining steel grade IS 2062 , 226

CHEMICAL COMPOSITION OF WELD METAL (%):

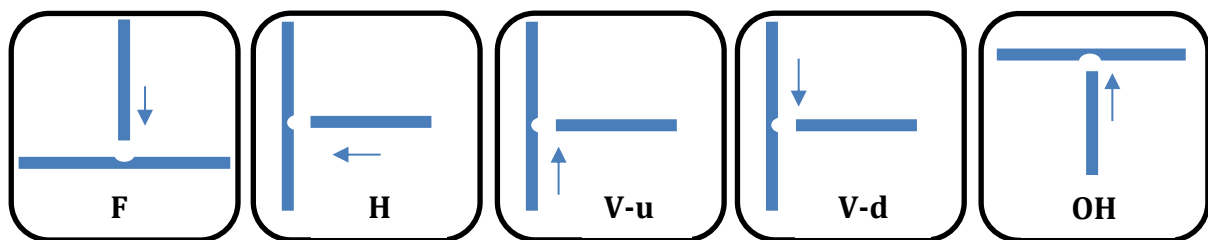
Elements	C	Mn	Si	S	P
%	0.10 Max	0.35-0.65	0.30 Max	0.035 Max	0.035 Max

MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (N/mm ²)	YS (N/mm ²)	Elongation %	CVN Impact at 0°C (J)
410 -540	330 Min	22 Min	47 Min

Bend Test 3 T 180°	Satisfactory
Radiography Test II Blue Standard	Satisfactory
Storage Stability	Satisfactory

WELDING POSITIONS: F, H, V-DOWN, V-UP , OH.



CURRENT CONDITION: AC/ DC (-)

PACKING DATA:

Size SWG	SIZE mm	No of electrodes /Packet	No of electrodes /Cartoon	Current in Amps
12	2.50 X 350	125	1500	80 - 110
10	3.15 X 350/450	90	1080	90 - 130
8	4.00 X 350/450	60	720	140 - 190
6	5.00 X 450	40	480	170 - 230