

**E 6013**

MILD STEEL GENERAL PURPOSE (MSGP)



Weld Company Limited

**CLASSIFICATION:**

EN ISO 14341-A

AWS A/SFA 5.1

**APPROVALS**

E38 OR 12

E 6013

CE/BIS/BHEL/IRS/IBR/Gr.2, DNV  
Gr.2, Ordnance, Factory Medak,  
Cethar Vessels, APPGCL**KEY FEATURES:**

- Easy arc striking and restricking.
- Rutile type -medium coated, all-position general-purpose electrode operates on both AC & DC.
- Easily peeling slag with least spatter.
- The weld metal possesses good mechanical properties and radiographic quality.

**WELDING POSITION:**

AC(50 OCV min.)/DCEN

**TYPICAL APPLICATIONS:**

- Ideal for welding of mild steel
- Sheet welding, structures
- Bridges, furnitures
- General Fabrication

**CHEMICAL COMPOSITION OF UNDILUTE WELD METAL:**

	<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>P</b>	<b>S</b>
Typical Value	0.05 – 0.10	0.30 – 0.60	0.12 – 0.35	0.03	0.03
Specification	0.20 max	1.20 max	1.00 max	0.03 max	0.03 max

**MECHANICAL PROPERTIES OF ALL WELD METAL:**

<b>Condition</b>		<b>UTS, Mpa</b>	<b>YS at 0.2 % offset, Mpa</b>	<b>EL%</b>	<b>CVN Impact at -0°C, JULES</b>
Typical	As Welded	430 - 450	360 - 420	22-30 min	60-80 J
Specification		430	330	17	47 J

**PARAMETERS – PACKING DATA:**

<b>Ø x L, mm</b>	<b>Amperage, A</b>	<b>Wt./Carton Kg</b>	<b>Carton/Box</b>	<b>Approx. wt. of 1000 pcs, Kg.</b>
2.5 x 350	60-90	135	8	20
3.15 x 350	100-140	90	8	21
4.0 x 450	140-190	60	8	28
5.0 x 450	180-240	40	8	30