

## SUITABLE WELDING POSITIONS:



## SAFETY NORMS FOR ELECTRODE USE:



ISO 9001:2015 CERTIFIED COMPANY

MANUFACTURER OF BEST IN CLASS WELDING ELECTRODES

"Rudramani" 1720, Laskarhat, EM Bypass, Kolkata 700039  
1800-309-3876 | contactus@groupnirmal.com

[www.groupnirmal.com](http://www.groupnirmal.com) | Follow Us:

## WHERE WELDERS MAKE THEIR MARK

- Dynamic Welding Scene
- Precision Focus
- High Mechanical Strength
- Innovative Technology
- Safety Emphasis
- Professional Finish

**NIRMAL 6013**  
WELDING ELECTRODES  
WELDER'S PREMIUM CHOICE

  
*Re-Imagining Tomorrow*



WELDING THE  
**FUTURE**

# NIRMAL 6013

WELDING ELECTRODES  
WELDER'S PREMIUM CHOICE



LOW SMOKE



LOW SPATTER



HIGH QUALITY WELD



SMOOTH FINISH

## CLASSIFICATION - AWS:E6013, IS:ER4124

### WELDING CURRENT (AMPS) D±, A70

5.00×450 MM	4.00×450 MM	3.15×450 MM	3.15×350 MM	2.50×350 MM
160-230	120-170	90-120	90-120	70-90

### WELD METAL ANALYSIS (AVERAGE VALUE)

C%	Mn.%	Si%	S%	P%
0.10 Max.	0.35-0.55	0.30 Max.	0.030 Max.	0.03%Max.

### TYPICAL MECHANICAL PROPERTIES

UTS	YS	Elongation %	Charpy'V'Notch at+27°C	Reduction of Area
410N/mm <sup>2</sup> Min	330 Min. N/mm <sup>2</sup>	L=5d 20 Min.	47(J) Min.	50% Min.

### PACKING DATA

Size in mm	Pcs. / Packet	Pcs. / Packet
2.5 X 350	100	600
3.15 X 350	90	540
3.15 X 450	90	540
4.0 X 450	60	360
5.0 X 450	40	240

## ELEVATING WELDING EXCELLENCE



BUILDING CONSTRUCTION

## PRECISION WELDING WITH EVERY SPARK



AUTO BODY FRAMES



PRESSURE PIPES



SHIPBUILDING



RAILWAY COACHES



STORAGE TANKS & BOILERS

Available in standard carton packaging  
of 12.5 - 21.5 kg box containing 6 cartons.