

ROYAL SUPER 60(E 6013)

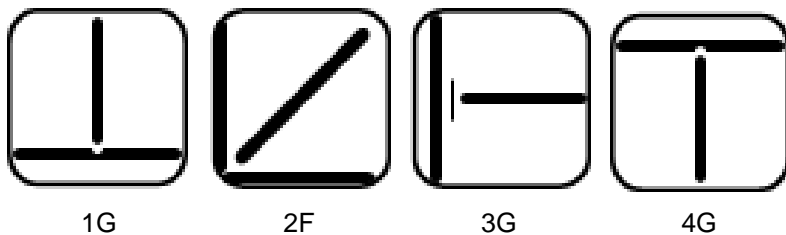
Applications

Structures & Building Construction Auto Bodies And Railway Wagons Grills, General Fabrication Vessels, Tanks, Pipelines, Bridges, Ships, Trailers.

Characteristics on Usage

A medium coated all position electrode with excellent striking and restriking with less smoke and fantastic weld bead finish. Good penetration, soft arc and low spatter, easy slag detachability. Specially designed for Low OCV machine.. It can be used in both AC & DC.

Welding Positions



Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%
0.20 Max	1.20 Max	1.0 Max	0.040 Max	0.040Max

Mechanical Properties Of Weld Metal

U.T.S.	Y.S.	ELONGATION	IMPACT (CVN)
(N/mm ²)	(N/mm ²)	(L = 4d) %	AT 0° C
450 Min	350 Min	22 % Min	47 Joules Min

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	2.5	25	AC / DC (-)	50 – 85
3.15 x 350	2.5	25		70 – 100
4.00 x 450	2.5	25		100 – 140
5.00 x 450	2.5	25		140 – 200