

ROYAL BOND (E 6013)

AWS : A 5.1, E 6013

IS : 814 ER 4222

Applications

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

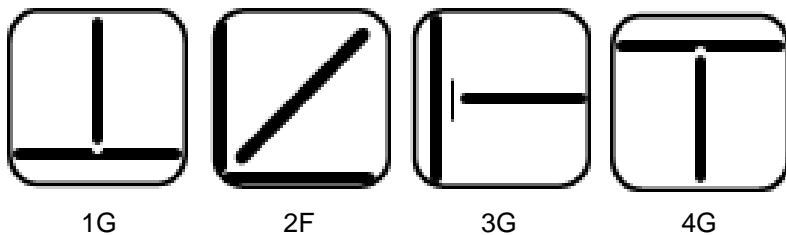
Characteristics on Usage

A medium coated all position electrode for work of structural importance with medium penetration, soft arc and low spatter, easy to detach slag. It can be used in both AC & DC.

Notes On Usage

1) Dry electrode at 70-100 °C for 30-60 min. before use.

2) Pay attention not to exceeds the range of proper current.

Welding Positions**Chemical Composition Of Weld Metal**

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

Approvals

I.R.S, I.B.R, L & T, A.P.G.L B.I.S [ISI], IOCL, TPL

Packing and Welding Current

SIZE (mm)	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 x 350	135	1350	AC / DC (-)	60 – 90
3.15 x 350	90	900		100 – 140
4.00 x 450	60	600		140 – 180
5.00 x 450	45	450		180 – 230