



Mild Steel General Purpose Electrodes ISPAT GOLD 6013

Characteristics:

ISPAT GOLD 6013 a medium coated all position welding electrode is rutile type for use in all purpose fabrication and smooth weld bead. Good properties even at low welding current. Mechanical Properties meet the requirement of all international codes for general purpose electrodes.

Applications

Structural Steels, Steel Furniture, Truck Bodies, Window Frames and Grills, Storage Tanks, Auto parts, Bridges, Wagons, Barges, Rail Coaches, Building Structures, Vessels, Agricultural Implements etc.

Typical Weld metal Composition

Element	Percent
C	0.070
Mn	0.45
Si	0.20
P	0.020
S	0.020

Typical Mechanical Properties of all weld Metal

Ultimate Tensile Strength N/mm ²	Yield Strength N/mm ²	Elongation % (L=5d)	CVN Impact Strength at 0 °C.J
486	415	22	58 J

Classifications:

AWS/ A5.1:	E 6013
IS: 814	ER 4211
BS 639:	E 4211 R 11

Current Range & Packing Data:

Size MM DxL	Current Range (Amps) AC or DC (+)	Pieces per Packet	Pieces per Case
6.30x450	240-280	25	300
5.00x450	190-230	40	480
4.00x450	120-180	60	720
3.15x450	100-120	90	1080
3.15x350	100-120	90	1080
2.50x350	60-80	135	1620

Approvals : Bureau of Indian Standard(ISI),

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