



## Mild Steel General Purpose Electrodes - VICTOR 6013

### Characteristics:

**Victor 6013** is a rutile type medium coated normal penetration electrode for all position welding on both AC & DC. Stable arc finely rippled bead, easy slag removal makes the electrode suitable for user. Mechanical properties of all weld metal are excellent and capable of meeting radiographic quality welds

### 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	0.075
Mn	0.55
Si	0.21
P	0.020
S	0.020

### Typical Mechanical Properties of all weld Metal

Ultimate Tensile Strength N/mm <sup>2</sup>	Yield Strength Kg/mm <sup>2</sup>	Elongation % (L=5d)	CVN Impact Strength at 0 °C.J
480	410	25	60 J

### Classifications:

<b>AWS/ A5.1:</b>	E 6013
<b>IS: 814</b>	ER 4211
<b>BS 639:</b>	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	180-240	40	480
4.00x450	140-180	60	720
3.15x450	100-120	90	1080
3.15x350	100-140	90	1080
2.50x350	60-90	135	1620

**Approvals : Bureau of Indian Standard (ISI),**

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