



Mild Steel General Purpose Electrodes ALPHA 6013 SS

Characteristics:

ALPHA 6013 SS is a heavy coated, rutile type, all position general purpose electrode for radiographic quality welds at high welding speed. A very soft arc, medium penetration, uniform, smooth and shiny bead with self peeling slag.

Applications:

Pressure vessels, Boilers, Locomotive fire boxes, scooter frames, Heavy girder fabrication, Bridges, Cranes, Machinery base, Storage tanks and where strength combined with finish is necessary.

Typical Weld metal Composition

Element	Percent
C	0.080
Mn	0.55
Si	0.28
P	0.027
S	0.022

Typical Mechanical Properties of all weld Metal

Ultimate Tensile Strength N/mm ²	Yield Strength N/mm ²	Elongation % (L=5d)	CVN Impact Values at 0 °C. J
490	410	24	66 J

Classifications:

AWS/ A5.1:	E 6013
IS: 814	E RR 4322 X
DIN 1913:	E 4322 RR 6
BS 639:	E 4322 RR

Current Range & Packing Data :

Size MM DxL	Current Range (Amps) AC or DC (-)	Pieces per Packet	Pieces per Case
6.30x450	250-320	35	140
5.00x450	190-260	40	160
4.00x450	140-220	65	260
3.15x450	100-140	105	420
2.50x350	60-100	175	700
2.00x350	40-60	290	1160

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