KARITO E6013

CLASSIFICATION & CODING

IS 814:2004 : ER 4211X
AWS 5.1 / SFA 5.1 : E6013

KEY FEATURES

- Rutile coated, medium-heavy type electrode.
- Stable arc, easy to strike and re-strike.
- Self-peeling slag with smooth, rippled bead appearance.
- Excellent all-position welding properties.
- X-ray quality weld metal with consistent results.
- Ideal for mild steel fabrication and general-purpose welding.

TYPICAL APPLICATIONS

- Railway Wagons
- Auto Bodies & Truck Fabrication
- Structural Steel Works
- Pipelines & Storage Tanks
- Building Fabrication
- Boilers & Fire Boxes
- Ship Building
- Machinery Construction
- Bridges
- Mild Steel Furniture

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (%)

Carbon	0.10 Max
Manganese	0.25 - 0.55
Silicon	0.60 Max
Sulfur	0.040 Max
Phosphorus	0.040 Max

TYPICAL MECHANICAL PROPERTIES OF WELD METAL

Yield Strength (Min)	440 N/mm2
Ultimate Tensile Strength	410 - 540 N/mm2
Elongation	22 - 28%
CVN Impact (-0C)	50 - 70 Joules

WELDING PARAMETERS

Parameter	Specification
Size (mm)	2.50x350 | 3.15x350 | 3.15x450 | 4.00x350 | 4.00x450 | 5.00x450
Amperage (A)	70-100 | 100-140 | 100-140 | 140-200 | 140-200 | 180-240
Polarity	AC / DC (+ / -)

RECOMMENDATIONS

- Ensure electrodes are completely dry before use.
- Re-dry moist electrodes at 105 degC for 30 minutes before welding.
- Use within the recommended current range for best results.
- Store in a clean, dry place away from moisture.
- Maintain short arc length and proper travel speed during operation.

KARITO - Trusted Welding Electrodes

www.karito.co.in | support@karito.co.in | +91-9599116787