

ROWELD-13S

A MEDIUM HEAVY COATED RUTILE TYPES ALL
POSITION WELDING ELECTRODE

BASIC ALLOY: C, FE, MN
AWS/SFA-5.1: E 6013
EN ISO 2560-A 38 0 R 11

KEY FEATURES:

A medium heavy coated rutile types all position welding electrode with weld deposit of radiographic quality. The electrode can be subjected to low OCV, offer smooth rippled bead appearance coupled with low spatter and fumes

APPLICATIONS

- Suitable for storage tanks.
- Rail coaches.
- Pressure vessels.
- Heavy structures and pipe welding works.
- Ship construction
- Structure works, Boilers etc.

RE-DRY CONDITION:

- Re-Dry the electrode at 120°C for 30-60 minutes, for best results.

CHEMICAL COMPOSITION:

C	Mn	Si	S	P	Mo
0.10 max.	0.40-0.60	0.30 Max	0.30 Max	0.30 Max	2.00-3.00

MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT @
350-470	450-540	22-30	0C : 50-80 J

WELDING POSITION



DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm) (Dia)	Size (inch) (Dia)	Current Condition (DC+/ AC) Amps	Kg/pkt.	Kg/Case
2.00 X 300	5/ 64"	50-75	5	20
2.50/ 2.40	3/ 32"	60-90	5	20
3.15/ 3.20	1/ 8"	100-130	5	20
4.00	5/ 32"	150-180	5	20
5.00	3/ 16"	190-230	5	20