

Shielded Metal Arc Welding

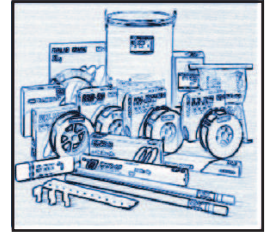
ANU BOND 6013

AWS: A 5.1 E6013 IS :814 ER 4221

Mild Steel Welding Electrodes

Application :

Structural & Building Construction, Auto Bodies & Railway Wagons, Grills General Fabrication Vessels, Tanks, Pipelines, Bridge, Ship, Trailers, Building up of shafts, Boilers.



Characteristics :

Medium Coated all position electrode for work of structural importance with medium penetration, Soft arc & low spatter, Easy to detach slag. It can be used in both AC & DC Current.

Chemical composition of All-Weld metal (%) as per AWS

C	Mn	Si	P	S
0.20 Max	1.20 Max	1.00 Max	0.04 Max	0.04 Max

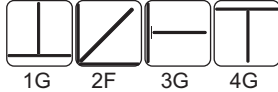
Mechanical properties of all-weld metal as per AWS

UTS	YS	Elongation	Impact
(N/mm ²)	(N/mm ²)	(L=4d) %	(CVN) at 0° C (J)
450 Min	350 Min	22.0% Min	47 Joules Min

Approvals

BIS, IRS , IBR

Welding Positions



Packaging & Welding Current

SIZE (mm)	Kg / Packet	Kg Per Carton	Current (Amps)	In Amps
2.50 x 350	2.50Kg	15 Kg	AC/ DC (-)	60- 90
3.15 x 350	2.50Kg	15 Kg		100- 140
4.00 x 450	3 Kg	15 Kg		140- 180
5.00 x 450	3 Kg	15 Kg		180- 230

