

METALBOND S

CLASSIFICATIONS

AWS/SFA 5.1 E6013

IDENTIFICATION: Name Printed

CHARACTERISTICS

A medium heavy rutile coated all position electrode for structural welding applications. Deposition efficiency is approximately 8-10% higher in comparison to other rutile coated electrodes of E6013 type. Hence, in fillet welds, total length of the fillet is about 10% more. The electrode produces a smooth arc, minimal spatter and the slag is extremely easy to remove. The bead is shiny and finely rippled. Suitable for welding in all-positions including vertical down fillets. Gives weld metal of radiographic quality.

TYPICAL APPLICATIONS

- Storage tanks, automobile bodies, bus bodies • Railway coach panels, galvanised sheets • Bridge structures, pressure vessel
- L.P.G. Cylinders, pipes & tubes • Shipbuilding • Steel furniture and sheet metal work

APPROVALS :

LRA 1M, NR **DNV** Gr-2
ABS Gr-2 **IRS** Gr-2
BV Gr-2

CURRENT CONDITIONS DC: AC Dc (±)

5.0	4.0	3.2	2.5
180-250	140-190	100-140	60-90

WELDING POSITIONS

F, H, V-up, OH, V-down

REDRYING CONDITIONS

None. Moist electrodes may be reconditioned at 100-110° C for ½ hr.

WELD METAL CHEMISTRY, (%)

C - 0.10 Max Mn - 0.60 Max Si - 0.35 Max
 S - 0.03 Max. P - 0.03 Max.

PACKING DATA

Dia., mm	5.0	4.0	3.2	2.5
Length, mm	450	450	450	350
Wt. per carton, kg	5	5	5	5
Cartons / box	4	4	4	4
Net wt per box, kg	20	20	20	20

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS MPa	YS MPa	% Elongation (L = 4xd)	CVN Impacts, J °C
As-welded	460-550	360-480	22-30	50 - 100



WELDERS TO THE NATION SINCE 1951
ADOR WELDING LIMITED

(Formerly Known as Advani-Oerlikon Ltd.)

www.adorwelding.com

