

ROYAL- S (E 6013)AWS : A 5.1, E 6013
IS : 814 ER 4212 X**Applications**

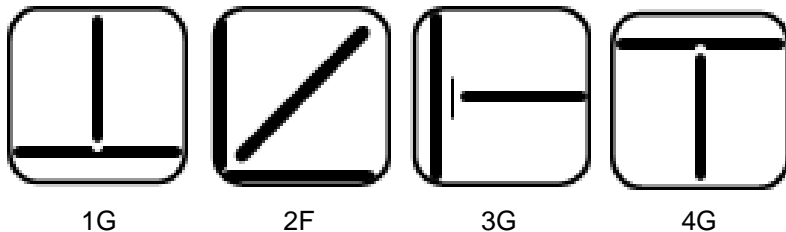
Ship Building Storage Tanks & Boilers Pressure Pipes Railway Coaches

Characteristics on Usage

A medium coated rutile type all position electrode with excellent welding characteristics for major structural works where finishing is of importance. Low spatter, smooth arc and easy slag removal, easy to operate in vertical upward position. Ideal where radiographic quality is required.

Notes On Usage

- 1) In case of varticle download welding,manipulate the electrode,keeping its tip in contact with base metal.
- 2) Dry the electrode at 70-100 °C for 30-60 min.before use.

Welding Positions**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%
0.12 Max	0.65 Max	0.40 Max	0.04 Max	0.04 Max

Mechanical Properties Of Weld Metal

U.T.S.	Y.S.	ELONGATION	IMPACT (CVN)	RADIOGRPHY TEST
(N/mm ²)	(N/mm ²)	(L = 5d)	AT 0° C	
460 - 560	370 – 480	22 % Min	47 Joules Min	Satisfactory as per IIW blue std

Approvals

I.R.S, L.R.S, I.B.R, B.V, D.N.V, P.D.I.L, B.I.S [ISI], TOYO[TEIL], THERMAX,L & T A.B.S, K.N.P.C., K.P.G. I.L, I.O.C.L,M.R.P.L, TPL UHDE INDIA LTD., M.M.D., B.H.P.V., N P C I L, RDSO CLASS A2,

Packing and Welding Current

SIZE (mm)	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 x 350	290	1160	AC 50 OCV / DC (-)	60 – 90
3.15 x 350	175	700		100 – 140
3.15 x 450	130	520		100 – 140
4.00 x 450	85	340		140 – 190
5.00 x 450	55	220		190 – 250