

# ROYAL SUPER 60(E 6013)

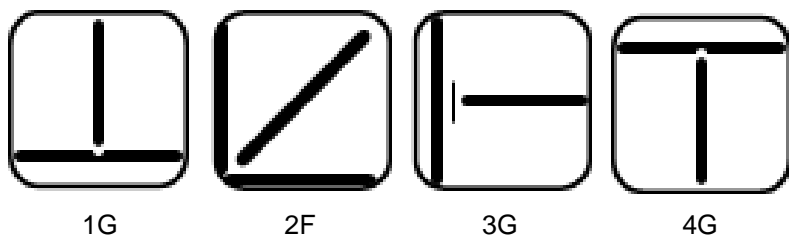
## Applications

Structures & Building Construction Auto Bodies And Railway Wagons Grills, General Fabrication Vessels, Tanks, Pipelines, Bridges, Ships, Trailers.

## Characteristics on Usage

A medium coated all position electrode with excellent striking and restriking with less smoke and fantastic weld bead finish. Good penetration, soft arc and low spatter, easy slag detachability. Specially designed for Low OCV machine. It can be used in both AC & DC.

## Welding Positions



## Chemical Composition Of Weld Metal

| C%       | Mn%      | Si%     | S%        | P%       |
|----------|----------|---------|-----------|----------|
| 0.20 Max | 1.20 Max | 1.0 Max | 0.040 Max | 0.040Max |

## Mechanical Properties Of Weld Metal

| U.T.S.               | Y.S.                 | ELONGATION   | IMPACT ( CVN ) |
|----------------------|----------------------|--------------|----------------|
| (N/mm <sup>2</sup> ) | (N/mm <sup>2</sup> ) | ( L = 4d ) % | AT 0° C        |
| 450 Min              | 350 Min              | 22 % Min     | 47 Joules Min  |

## Packing and Welding Current

| SIZE ( mm ) | KG PER PACKET | KG PER CARTON | Current (Amps) | In Amps   |
|-------------|---------------|---------------|----------------|-----------|
| 2.50 x 350  | 2.5           | 25            | AC / DC (-)    | 50 – 85   |
| 3.15 x 350  | 2.5           | 25            |                | 70 – 100  |
| 4.00 x 450  | 2.5           | 25            |                | 100 – 140 |
| 5.00 x 450  | 2.5           | 25            |                | 140 – 200 |