



SMOOTHARC 6013

Coated Mild Steel Electrode

SMOOTHARC 6013 is a medium heavy rutile coated mild steel electrode designed for welding of unalloyed structural steels in all positions. The electrode gives smooth radiographic quality weld with low spatter and smoke. Slag is self-detachable and the bead shape is uniform and finely rippled.

Classifications: SFA/AWS A5, 1:E6013, EN ISO 2560 – A:E 38 0 RC 11, IS 814:ER4212X

Mechanical Properties:

Yield Strength: 420 MPa
Tensile Strength: 520 MPa
Elongation: 28%
Impact Value: 90J, 0 deg C

Chemical Composition:

Alloy Type: C-Mn
Coating: Rutile

C	Si	Mn	P	S
0.07	0.34	0.4	0.015	0.013

Welding Parameters:

Welding Positions: Flat, Fillet, Vertical Up, Horizontal, Overhead

Current Range:
Polarity: AC/DC+

Diameter (mm)		3.2	4.0	5.0
Length (mm)		350	450/350	450
Current (A)	F, V, H	90-130	120-180	170-230
	V, OH	80-120	110-170	160-220

PHILARK ALLOYS

REGD. OFFICE & WORKS: E 37, UPSIDC, MG ROAD, HAPUR, UP



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