

KINGBOND

E 6013 Welding Electrodes



Classification:

AWS A/SFA-5.1: E 6013
IS 814 ER 4211X

Approvals: BIS 814 E4211X

Identification: Name printed

Current Conditions: DC (+-)/AC(50V)

- Operates at as low as 50V OCV
- Easy Arc striking / re-striking
- Very low spatter level
- All-Position welding including Vertical down
- Self peeling slag
- Excellent bead finish, smooth weld toe
- Radiographic Quality Weld
- Toughness up to zero degree
- Comes with BIS certification
- High current carrying capacity



WELDERS TO THE NATION SINCE 1951
ADOR WELDING LIMITED

(Formerly Known as Advani-Oerlikon Ltd.)

www.adorwelding.com



KINGBOND

E 6013 Welding Electrodes

Characteristics

Medium rutile coated electrode with X-ray quality and excellent Weldability in all positions including vertical-down. Needs only 50V when AC Transformer is used. Gives medium penetration, least spatter and easy slag detachability. Striking and re-striking is very good. Weld metal is of radiographic quality.

Typical Applications

- Steel plants – general fabrication of mild structural steels like IS 2062, 226 etc.
- Storage tanks. • All kinds of light constructional work.
- Shipbuilding. • Sheet metal work, furniture. • Automobile bodies. • Pipes.



Welding Currents (Amps)

5.00 mm	4.0 mm	3.15 mm	2.50 mm
180-240	140-180	90-130	60-85

Typical Weld Metal Chemistry, Wt %

C : 0.12 max.	Mn : 0.25-0.55	Si : 0.12-0.35
S : 0.03 max	P : 0.03 max	

Weld Metal Properties (As welded condition)

UTS	YS	Elongation % (L=4d)	CVN Impact
450-540 N/mm ²	370-480 N/mm ²	22-28%	At 0 °C = 50J (min)

Readying Conditions: None. If moist re-dry at 70-110°C for 30-60 minutes.

Packing Specifications

Dia, mm	5.00	4.00	3.15	3.15	2.50
Length, mm	450	450	450	350	350
Pieces per carton	35	55	85	85	140
Cartons/box	6	6	6	6	6
Pieces per box	210	330	510	510	840



WELDERS TO THE NATION SINCE 1951
ADOR WELDING LIMITED
 (Formerly Known as Advani-Oerlikon Ltd.)



www.adorwelding.com

Registered & Corporate Office: Ador House, 6, K. Dubash Marg, Fort, Mumai 400 001. INDIA.
 Tel: +91 22 2284 2525. Fax: +91 22 2287 3083 Email: cmo@adorians.com