



Mild Steel General Purpose Electrodes – SRI RAM SUPER 6013

Characteristics:

SRI RAM ARC SUPER 6013 is a , rutile type, general purpose electrode for all position welding of mild steel , with excellent ductility and good penetration. Designed for a wide range of applications.

Applications:

Building Construction, Steel Structural , Steel Furniture, Truck Bodies, Window Frames and Grills, Storage Tanks, Auto parts, Bridges, Wagons, Barges, Rail Coaches, Building Structures, Vessels, Agricultural Implements etc.

Typical Weld metal Composition

Element	Percent
C	0.075
Mn	0.55
Si	0.21
P	0.020
S	0.020

Typical Mechanical Properties of all weld Metal

Ultimate Tensile Strength N/mm ²	Yield Strength N/mm ²	Elongation % (L=5d)	CVN Impact Strength at 0 °C.J
480	410	25	60 J

Classifications:

AWS/ A5.1:	E 6013
IS: 814	ER 4211
BS 639:	E 4211 R 11

Current Range & Packing Data :

Size MM DxL	Current Range (Amps) AC or DC (+)	Pieces per Packet	Pieces per Case
6.30x450	240-280	25	300
5.00x450	180-240	40	480
4.00x450	150-180	60	720
3.15x450	100-120	90	1080
3.15x350	100-120	90	1080
2.50x350	60-90	135	1620

Approvals : Bureau of Indian Standard (ISI),

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