

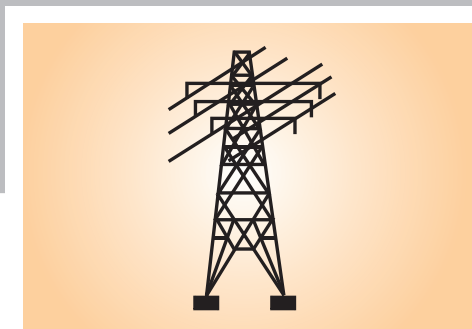
ESSEN® GP

AC/ DC +

Mild Steel electrodes For effective surface treatment

A5.1 E6013

Medium coated rutile-cellulosic electrode most suitable for general purpose fabrication in mild steel



PROPERTIES

An all position electrode for contact type of welding & for low penetration. Easy to weld at low amperages and at low open circuit voltages. Easy to remove slag..

MECHANICAL PROPERTIES

Tensile strength: 49 Kg / mm² (~ 70,000 psi) Elongation: 21 %

APPLICATIONS

For sheet metal fabrication of mild steel strusses, structures, tanks, pipelines, mild steel bases for pumps & motors, frames, fabrication of different sections like T,I,H, beams, also for built up or overlaying on worn out parts of m.s. and also joining dissimilar thickness.

WELDING PROCEDURE.

Clean weld area. Use AC / DC reverse polarity. Maintain a short arc. Thin gauges can be contact welded

| RECOMMENDED AMPERAGE | |
|----------------------|----------------|
| Size | Current |
| 3.15mmx 350mm | 060 - 125 Amps |
| 4.00 mm x 450 mm | 095 - 160 Amps |

| PACKING | |
|------------------------|---------------------|
| 3.15 mm x 350 mm 30 kg | 36 pcs/kg (Approx.) |
| 4.00 mm x 450 mm 28 kg | 17pcs/kg (Approx.) |



ESSEN
WELDING ALLOYS PVT. LTD.



ESSEN & AZUCAR
PREMIUM WELDING ALLOYS

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