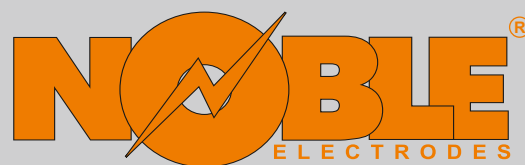


NOBLE - 6013

Mild Steel General Purpose Electrodes



CLASSIFICATION

AWS - A 5.1: E6013

Characteristics : NOBLE - 6013 is a medium coated Rutile type all position general purpose electrode which gives uniform deposition, smooth arc characteristics and good re-striking properties. The electrode operates on AC as well as DC power source.

Applications : For all kind of mild steel structures like ship hulls, tanks & vessels, bridges, railway wagons, steel frames & grills, truck bodies etc.

Mechanical Properties

Mechanical Tests	Required Values
Yield Strength	330 N/mm ² (Min.)
Tensile Strength	410 - 540 N/mm ²
Elongation	20 % (Min.)
Impact (CVN) at 27°C	47 J (Min.)

* If Moist: Re-dry at 120°C For 1 Hr.

Weld Metal Chemistry (%)

Elements	C	Mn	Si	P	S
Range	0.12 Max	0.60 Max	0.40 Max	0.040 Max	0.040 Max

Packing Specifications & Current Condition

Size (mm)	Pkts. / Case	Pcs. / Pkt	Current (Amp.) AC (50V) DC (±)
2.00 x 350	12	2.500 Kg.	50 - 70
2.50 x 350	12 / 08	135 / 2.500 Kg.	60 - 90
3.15 x 350	12	90 & 2.500 Kg.	100 - 140
3.15 x 350	04	175	100 - 140
3.15 x 350	08	90	100 - 140
3.15 x 450	04	175	100 - 140
4.00 x 450/350	08	60 & 3.500 Kg.	140 - 200
4.00 x 450	04	105	140 - 200
5.00 x 450	08	45	180 - 250

“Noble – Characterized by all Excellent Qualities”