

VALIANT

VALIANTWELD - 6013

AWS : A5.1 : E 6013 IS : ER 4211 X

Valiantweld is a medium-Heavy coated, electrode designed to operate even with 45 OVC. The smooth and stable arc is easy to strike and restrike, least spatter and smoke, self peeling slag. The electrodes operate in all conventional positions and is of radiographic quality.

CHEMICAL COMPOSITION

C	Mn	Si	S	P
0.10	0.65	0.30	0.028	0.030

MECHANICAL PROPERTIES

UTS (Kg/mm)	YS (Kg/mm ²)	EI (L = 4D)%	CVN Impac strength at (Joules) 20°c
49.0	44.2	30	55J

WELDING PARAMETERS

	Size (mm)	Current (Amp.)
AC/DC (-)	6.30 X 450	230-340
	5.00 X 450	200-260
	4.00 X 450	140-190
	3.15 X 450	100-125
	3.15 X 350	100-135
	2.50 X 350	60-90

APPLICATION

Suitable for all types of mild steel structures, plant and machinery, pipes, dredgers, trawlers, railway wagons, ship building, storage tanks etc.

INDIA

Decolite Industries
73, Pologround,
Industrial Estate
Indore, M.P. 452015, India

UAE

Blasting Equipments and Abrasive Trading
Ras Al Khaimah, UAE
Tel: +97-1-552875841, +97-1-552875840
E mail: info@valiantweld.com

E-mail

mkt@valiantweld.com
robin@sptwelding.com



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