

# Spark Gold

Type: Rutile E 6013

## Description

Heavy coated rutile mild steel electrode with superior welding performance. Very smooth & controlled arc gives excellent radiographic quality. Welds with good elongation and impact properties. Excellent slag detachability with shiny mitre beads. Very good positional welding performance.

## Welding current

DC(+ -), AC 50 V

## Application

- Steel Structures subject to dynamic loading
- General Fabrication
- Tanks and Vessels
- Railway Bogies & Underframes
- Ship Building & Pipe Welding

Description	Size	Pcs/
SPARK Gold	2.50X350	53
SPARK Gold	3.15X350	35
SPARK Gold	3.15 X 450	27
SPARK Gold	4.00 X 450	17
SPARK Gold	5.00 X 450	12

## Welding Parameters

Diameter	Length	Welding	Arc voltage
mm	mm	current, A	V
2.5	350	50 - 90	23
3.15	350	80 -135	24
3.15	450	80 -130	24
4.0	450	120 -190	25
5.0	450	170 -270	26

## Classifications

SFA/AWS A5.1	E 6013
IS : 814	ER 4211X

## Typical all weld metal composition, %

C	Si	Mn
<0.08	0.25	0.45

## Typical mech. properties all weld metal

Yield stress, MPa	420
Tensile strength, MPa	490
Elongation, %	24

## Charpy V

Impact (CVN) at 0°C	65 J
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