

Spark Silver

Type: Rutile E 6013

Description

Medium coated rutile general purpose mild steel electrode with excellent welding performance. Smooth arc operates down to 50 OCV. Minimum smoke & spatter. Radiographic quality welds with good mechanical properties. Excellent slag detachability with shiny, neat bead. Welds in all positions including vertical and down.

Welding current

DC + / - , AC 50 V

Application

- Grills, Gates
- Tubular Furniture
- Truck / Bus Bodies
- Sheet Metal Fabrication
- Chimneys and Pipe Welding

Description	Size	Pcs/ Kg
SPARK Silver	2.50X350	53
SPARK Silver	3.15X350	35
SPARK Silver	3.15 X 450	27
SPARK Silver	4.00 X 450	17
SPARK Silver	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	80-130	24
3.15	450	80-125	24
4.0	450	120-185	25
5.0	450	170-260	26

Classifications

SFA/AWS A5.1	E6013
IS : 814	ER 4211X

Typical all weld metal composition, %

C	Si	Mn
<0.08	0.25	0.40

Typical mech. properties all weld metal

Yield stress, MPa	440
Tensile strength, MPa	500
Elongation, %	22

Charpy V

Impact (CVN) at RT	65J
--------------------	-----

