

# Product Data Sheet

MILD STEEL ELECTRODE

**BRAND NAME** VJ 6013

**AWS/ASME Class** E 6013

**SPECIFICATION** SFA 5.1 IS 814 : ER 4211



## Features and Applications :

VJ 6013 is a medium-coated rutile type, all-position, general-purpose electrode. It operates efficiently on both AC and DC (+), producing fine, rippled weld beads with easily removable slag for smooth, clean finishes.

VJ 6013 is suitable for all structural and sheet metal welding, building hulls, tanks, vessels, bridges, railway wagons, steel frames, truck bodies, fertilizer plants, and boiler components. It is a versatile choice for both general fabrication and specialized industries, ensuring high-quality welds with ease of use.

## CHEMICAL COMPOSITION :

All Weld Metal (%)	
TYPICAL	Max
C	0.2
Mn	1.20
Si	1.00

## MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - As Welded	
Properties	Typical
YS (MPa)	410-460
UTS (MPa)	460-550
El (%)	22-26
Charpy V at 0°C (J)	50-80

## DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)	
	Min	Max
Dia x Length		
2.50 x 350	70	100
3.15 x 350	90	140
3.15 x 450	90	140
4.00 x 450	140	190
5.00 x 450	190	250

## CURRENT : AC/DC (+)

## WELDING POSITION:

