

Product Data Sheet

MILD STEEL ELECTRODE

BRAND NAME VJ 6013X

AWS/ASME Class E 6013

SPECIFICATION SFA 5.1 IS 814 : ER 4222X



Features and Applications :

The VJ 6013X is a medium-coated rutile-type, all-position electrode, compatible with both AC and DC (+). It delivers fine, rippled weld beads with easy slag removal, ensuring clean and smooth welds. Ideal for applications such as hulls, tanks, vessels, bridges, steel frames, truck bodies, fertilizer plants, and boilers, it offers reliable performance across a variety of welding tasks.

CHEMICAL COMPOSITION :

All Weld Metal (%)	
TYPICAL	Max
C	0.10
Mn	0.40- 0.60
Si	0.35

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:

