

# Product Data Sheet

MILD STEEL ELECTRODE

**BRAND NAME** VJ 6013XX

**AWS/ASME Class** E 6013

**SPECIFICATION** SFA 5.1 IS 814 : ER 4222X



## Features and Applications :

The VJ 6013XX is a premium, heavy-coated rutile electrode designed for all-position welding, providing exceptional performance on both AC and DC (+) currents. It produces fine-rippled weld beads with easy slag removal, ensuring consistent, high-quality results. Ideal for a wide range of applications, including the fabrication of hulls, tanks, vessels, bridges, railway wagons, steel frames, truck bodies, and installations in fertilizer plants and boilers,

## 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:

