

# Product Data Sheet

## Zodian Universal™ E6013



Meeting the fabrication industry's highest welding expectations

### Description and Applications

Zodian Universal E6013 is a rutile-coated, general-purpose, mild steel/carbon steel, welding electrode. It has high arc force, good penetration and easy slag detachability resulting in quality welding joints even on rusty plates and uneven joints. It is suitable for all-positional welding and is particularly suited for downward, horizontal and vertical conditions.

### Classification

AWS A/SFA 5.1-91 E6013;  
EN 499 E 38 0 RC 11;  
EN ISO 2560-A E 38 0 RC 11

### Type of covering

Rutile-cellulosic electrode

### Type of current

AC, DCEP or DCEN

### Welding positions



### Current range:

Dia x length (mm)	2.5 x 305	3.25 x 350	4.0 x 350	5.0 x 350
Current (amps)	70-90	90-120	130-190	180-230

### Chemical composition of deposited metal (%)

	C	Si	Mn	S	P
Min	0.04	0.20	0.30		
Max	0.10	0.40	0.60	0.03	0.03

### Mechanical properties of deposited metal (AW)

Tensile strength (N/mm <sup>2</sup> )	Yield strength (N/mm <sup>2</sup> ) minimum	Elongation (%) minimum	Charpy V impact values at 0°C minimum
470-600	380	24	47 (Joules)

### Storage and redrying:

A certain amount of dampness can be tolerated but for the best results, redrying at 90°C for 30-40 minutes recommended for best results.

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