

**WELDING CONSUMABLES
GENERAL PURPOSE ELECTRODES**

ESR-11 E6013 GENERAL PURPOSE ELECTRODE

- All Position
- Extremely Stable Arc
- Good Arc Starting and Restrike
- Self Releasing Slag
- Low Spatter Level
- Good Weld Bead Appearance
- International Approvals


Classification

AWS SFA A-5.1 E6013 • AWS/ASME SFA-5.1 E6013 • DIN 1913 E43 22 R(C)3

General-purpose electrode for structural steelwork, workshop and maintenance welding. Easily operated in positional welding, including vertically-down. Good gap-bridging and smooth arc, well suited for tack-welding due to its easy arc striking and restriking properties. Welds are smooth, slightly concave and blending into base metal without undercutting. Suitable for welding on galvanized, primer painted and slightly rusted components.

Typical Mechanical Properties of Weld Metal

Yield Stress	Tensile Strength	Elongation	Impact Values
480Nmm ²	530N/mm ²	27%	80J@0°C

Typical Weld metal Analysis

C: 0.08% Si: 0.3% Mn: 0.5%

Part-No	Description	Pkt Weight
ESR1125-25P	ESR11 Electrode 2.5mm	2.5kg
ESR1125-50P	ESR11 Electrode 2.5mm	5.0kg
ESR1132-25P	ESR11 Electrode 3.2mm	2.5kg
ESR1132-50P	ESR11 Electrode 3.2mm	5.0kg
ESR1140-65	ESR11 Electrode 4.0mm	6.5kg

