



ISO 9001:2015  
Quality Certified  
by **Quality Austria**

# SAMURAI®

## ARC Welding Electrodes for MILD STEEL

### E6013 Samurai Brand Electrode

Mild Steel Electrode for General Purpose Welding.

Classification- AWS A/SFA5.1, Is814

#### Key features: -

Rutile coated (2) All Position operating characteristic (3) Suitable for general purpose structural steel fabrication (4) Quick freezing slag (5) Light to medium penetration on thick sheet metal (6) Can operate on DCEP (50 OCV ). 7) Soft arc (7) Low Spatter (8) Smooth restriking

**Welding Position: -** 1G, 2F, 3G ,4G

#### Chemical Composition of weld metals:

C%	Mn%	Si%	S%	P%
0.10 Max	0.6 Max	0.4 Max	0.04 Max	0.04 Max

#### Mechanical Properties of Weld metals:

UTS (N/mm2)	Y.S (N/mm2)	Elongation (%) 4d	CVN Impact (J) at Zero degree centigrade
530	440	27	61

**Typical Applications: -** Truck frame bodies, storage tank, construction equipment, steel furniture, Machinery, Light gauge work, Foundry equipment

#### Parameter's – Packing data:

Diameter x L(mm)	Current (Amp)	Wt./packet (Kg)	Packet/Carton (No)	Net Weight/Carton(Kg)
2.5mm x 350mm	50 - 90	5	4	20
3.2mm x 350mm	100 - 130	5	4	20
4.0mm x 350mm	140 - 180	5	4	20

Approved by: NHS  
An ISO 9001:2015 Company from IQNET Austria

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