

Classification of Mild steel electrode

– E 6013

Letter E indicates covered electrode for MMAW process manufactured by extrusion process.

Digit 60 indicate minimum weld metal UTS of 60,000 psi

Digit 1 indicates the position – all position except vertical down

Digit 3 indicates the type of coating **current condition- High titania, Potassium & AC ,DC+/-**

Digit -1

1 All Position
2 Horizontal & Flat
3 Flat position
4 Flat , Overhead, Horizontal, Vertical down

Digit -3

0 DCEP, Cellulosic , Na
1 AC/ DCEP, Cellulosic , K
2 AC/ DCEN, Rutile , Na
3 AC/ DCEP/ DCEN, Rutile , K
4 AC/ DCEP/ DCEN, Rutile , Fe
5 DCEP, Low Hydrogen , Na
6 AC/ DCEP, Low Hydrogen , K
8 AC/ DCEP, Low Hydrogen , Fe
20 AC/ DCEN, Fe oxide , Na
22 AC/ DCEN/DCEP, Fe oxide , Na
24 AC/ DCEN/DCEP, Rutile , Fe Powder
27 AC/ DCEN/DCEP, Fe Oxide , Fe Powder
28 AC/ DCEP, Low Hydrogen , Fe powder
48 AC/ DCEP, Low Hydrogen , Fe powder