

## ZULFI E6019

### CLASSIFICATION

AWS A5.1 E 6019

### APPROVALS

ABS  
BV  
DNV  
GL  
LRS

### GRADE

-  
-  
-  
-  
-

## PROPERTIES

Rutile-iron oxide coated MMA electrode for producing tough weld matrix compare with E6013. Smooth slightly concave welds blending into base metal without undercut, self-releasing slag, smooth and stable arc, less spatter. It can be used for fillet as well as butt welding even up to 1 inch plate without any problem. Weld metal having very good mechanical properties.

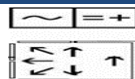
## APPLICATIONS

General structural application where mild steel is used. Storage tanks, railway wagons, pipe lines, sheet metal works, steel structures, truck frames and bodies, bridges etc. Suitable for joining steels like A, B, C, D grades of ASTM SA-283 (P.No.1).

### CHEMICAL ANALYSIS [TYPICAL VALUES IN %]

C	Mn	Si	P	S	Cr	Ni	Mo	Cu
0.08	0.70	0.3	0.02	0.015	0.03	0.01	0.01	0.02

### CURRENT CONDITION & WELDING POSITION



## ALL-WELD METAL MECHANICAL PROPERTIES

HEAT TREATMENT	YIELD STRENGTH (MPa)	TENSILE STRENGTH (MPa)	ELONGATION %	IMPACT STRENGTH
As Welded	≥ 350	≥ 450	≥ 22	50J at -20°C

## PACKING DATA

DIAMETER (MM)	LENGTH (MM)	CURRENT (A)	WEIGHT PER PACKET (KG)	NO. OF PACKETS PER CARTON
2.6	300	70-90	2.0 / 5.0	8/4
3.2	350	90-130	4.0 / 5.0	4
4.0	350	130-180	4.0 / 5.0	4
5.0	350	180-230	4.0 / 5.0	4