

GEMINI D1 [6013]

SPECIAL GRADE WELDING ELECTRODE

2IN1 FOR
✓ GALVANIZED STEEL
✓ GENERAL STEEL



STRUCTURAL WORK



ARCHITECTURE WORK



FURNITURE WORK



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GEMINI D1 [6013]

MILD STEEL AND LOW ALLOY STEEL

DESCRIPTION & APPLICATIONS

Gemini D1 [6013] is a high quality rutile electrode for use in all positions including vertical downwards. The electrode has a smooth arc action, low spatter with good striking and good slag detachability. Suitable for mild steel sheet, galvanized, constructed ship, train and automotive industries. Also used for structural work, fabrication, machine parts, metal buildings and structures, and shaft build-up.

Coating Type Rutile

Classification AWS A 5.1 : E6013 , EN ISO 2560-A : E 42 0 RR 12

TYPICAL CHEMICAL COMPOSITION OF ALL-WELD METAL(%)

Classification	C	Mn	Si	P	S
AWS : E 6013	0.20 max	1.20 max	1.00 max	Not Specified	Not Specified
Result	0.06	0.28	0.22	0.011	0.008

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL

Condition	AWS : E 6013	As Welded
Tensile Strength (MPa / ksi)	430 (60) min	550 (79)
Yield Strength (MPa / ksi)	330 (48) min	507 (73)
Elongation (%)	17 min	29
Charpy V-Notch Impact Value at -20 oC (J)	Not Specified	120 J

RECOMMENDED OPERATING PARAMETER

Diameter(mm)	Type of Power	Current (A)
2.0	DCEP, EN or AC	30 - 50
2.6	DCEP, EN or AC	40 - 80
3.2	DCEP, EN or AC	90 - 110
4.0	DCEP, EN or AC	130 - 160
5.0	DCEP, EN or AC	170 - 210

WELDING POSITION



APPROVALS

ABS (2), LR (2) , BKI , TIS