

Mild Steel General Purpose Electrode

CLASSIFICATION :

AWSA/SFA 5.1 E 6013

IS 814 ER 4211

KEY FEATURES :

- Rutile type medium coated
- Operates at low OCV
- Vertical down welding capability
- Suitable for major structural work

TYPICAL APPLICATIONS :

- General fabrication in steel plants
- Light construction work
- Shipbuilding, Pipes
- Storage tanks, Furniture work
- Automobile bodies
- Joining steel grade IS 2062, 226

WELDING POSITION :



POLARITY : AC/DCEN/DCEP

TYPICAL WELDMETAL CHEMISTRY

| Elements | C % | Mn % | Si % | S % | P % |
|---------------|----------|-------------|-------------|----------|----------|
| Typical | 0.10 | 0.40 | 0.30 | 0.02 | 0.02 |
| Specification | 0.12 Max | 0.25 - 0.55 | 0.12 - 0.35 | 0.03 Max | 0.03 Max |

MECHANICAL PROPERTIES OF ALL WELD METAL :

| | Condition | UTS, MPa | YS, MPa | Elongation, %a | CVN Impact @ 0°C, 3 |
|---------------|-----------|-----------|-----------|----------------|---------------------|
| Typical | As Welded | 520 | 440 | 24 | 57 |
| Specification | | 450 - 540 | 370 - 480 | 22 - 28 | 50 min |

PARAMETERS - PACKING DATA :

| B x L, mm | Amperage, A | Approx. Pcs / Packet | Packets / Box | Approx. wt of Packet | Approx. wt of Box |
|------------|-------------|----------------------|---------------|----------------------|-------------------|
| 2.50 x 350 | 60 - 85 | 125 | 12 | 2.50 Kg | 30.00 Kg |
| 3.15 x 350 | 90 - 130 | 90 | 12 | 2.50 Kg | 30.00 Kg |
| 3.15 x 450 | 90 - 130 | 90 | 8 | 3.20 Kg | 25.60 Kg |
| 4.00 x 450 | 140 - 180 | 60 | 8 | 3.50 Kg | 28.00 Kg |
| 5.00 x 450 | 180 - 240 | 40 | 8 | 3.60 Kg | 28.80 Kg |