

Mild Steel & Low Hydrogen Electrodes

ECONOMY

CLASSIFICATION

AWS SFA : A 5.20 E 71 T-5 C

DESCRIPTION AND APPLICATIONS

A general purpose, medium coated, all position, rutile type electrode suitable for general fabrication, structural and maintenance work in mild steel. The electrode is characterised by stable and smooth arc, low spatter, good deslagging and finely rippled weld bead. Weld deposit possesses good mechanical properties.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL (%)

C	Mn	Si	S	P
0.10 Max	0.60 Max	0.30 Max	0.03 Max	0.03 Max

TYPICAL MECHANICAL PROPERTIES

UTS mpa	YS mpa	Elongation (%)	CVN Impact at 0°C Joule
478.5	434.0	28.0	63.0

ELECTRODE SIZE AND 15 WELDING CURRENT : AC/DC (-)

UTS mpa	YS mpa	Elongation (%) at 0°C
2.50 x 350	60-90	260
3.15 x 350	100-140	150
3.15 x 450	100-140	150
4.00 x 450	140-180	95
5.00 x 450	180-220	65
6.30 x 450	270-320	35

APPROVALS: BIS (ISI), IRS, ASRTU
EACH BOX CONTAINS FOUR CARTONS.