

Mild Steel & Low Hydrogen Electrodes

EXCELLO

CLASSIFICATION

E -6013, IS : ERR422IX

DESCRIPTION AND APPLICATIONS

EXCELLO is heavy coated rutile type electrode with very quiet and stable arc, negligible spatter, self peeling slag, exceptionally clean, shiny and smooth bead, suitable for welding pressure vessels, boilers, storage tanks, furnace shells, locomotive fire boxes, bridges, auto frames, wagons and rail coaches etc. welds are of Radiographic quality.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL (%)

C	Mn	Si	S	P
0.10 Max	0.60 Max	0.20- 0.30	0.03 Max	0.03 Max

TYPICAL MECHANICAL PROPERTIES

UTS mpa	YS mpa	Elongation (%)	CVN Impact at 0°C Joule
475.5	431.5	28.0	70.0

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

SIZE DxL(MM)	CURRENT Amps.	PIECES /CARTO
2.50X350	60-100	175
3.15X450	100-140	105
4.00X450	140-200	65
5.00X450	190-230	40
6.30X450	230-340	25
6.30X450	270-320	30
6.30X450	270-320	30

APPROVALS:
BIS (ISI), CIB (MP)
EACH BOX CONTAINS FOUR CARTONS.