

## Mild Steel & Low Hydrogen Electrodes

### PRIMA

#### CLASSIFICATION

E-7016, IS : EB 5324 H2 X

#### DESCRIPTION AND APPLICATIONS

A basic coated, low-hydrogen electrode. deposits high quality welds having good strength and ductility at sub-zero temperature, suitable for welding mild steel, medium high tensile steels, Low- alloy steels, steels of unknown composition, welding of highly restrained joints and for non machinable welds on Cast Iron. Typical applications include heavy machinery such as cranes, rollers, tractors, earth moving equipments, ship, Railway Coaches & Cast Iron etc.

#### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL (%)

C	Mn	Si	S	P
0.10 Max	1.60 Max	0.75 Max	0.03 Max	0.03 Max

#### TYPICAL MECHANICAL PROPERTIES

UTS mpa	YS mpa	Elongation (%)	CVN Impact at 0°C Joule
555.0	475.0	28.0	78.5

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

SIZE DxL(MM)	CURRENT Amps.	PIECES /CARTO
2.50X350	70-100	225
3.15X450	90-140	130
4.00X450	140-200	85
5.00X450	190-250	55
6.30X450	240-320	30

**APPROVALS:**  
BIS (ISI), RDSO  
EACH BOX CONTAINS FOUR CARTONS.