

Mild Steel & Low Hydrogen Electrodes

STANDARD

CLASSIFICATION

AWS : E-6013, IS : ER4221X

DESCRIPTION AND APPLICATIONS

A medium coated, rutile type, all position electrode which can be described as TOUCH' electrode since it can be operated without maintaining an arc gap. Suitable for all types of mild steel structures, tanks and vessels, pipe lines, railway wagons, bridges, ship hull, boilers etc. The weld metal is sound, ductile and is 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
480.5	435.5	28.0	65.0

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

SIZE DxL(MM)	CURRENT Amps.	PIECES /CARTO
2.00X300	40-60	250
2.50X350	60-90	225
3.15X350	100-140	130
3.15X450	100-140	130
4.00X450	140-190	85
5.00X450	180-220	55
6.30X450	270-320	30

APPROVALS:
BIS (ISI), RDSO, CIB (MP), NPCIL, LRS,
ABS, BV, DNV, IRS, MMD, NTPC, IOCL, BHEL,
EIL, PDIL, M.N. Dastur & Co.
EACH BOX CONTAINS FOUR CARTONS.