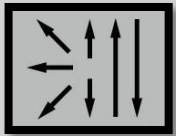


Classification					
AWS A5.1	IS 814				
E 6013	ER 4211X				
Characteristics and field of use					
<p>It is a medium coated rutile type electrode for all position welding. Smooth & stable arc with low spatter ,easy slag removal and fine rippled bead are special characteristics. Weld deposit has good chemical and mechanical properties with radiography quality. Welding of structural steels, truck bodies, dies ,steel furniture ,maintainace work & general fabrication of steel are the applications of this product.</p>					
Base Materials					
<p>Steels upto a yield strength of 380 Mpa, S235JR-S355JR, S235JO- S355JO, P195TR1-P265GH, P195GH-P265GH, L245NB- L360NB, L245MB-L360MB, shiplbuilding steels: A,B,D ASTM A 106, Gr.A, B; A283 Gr. A, C; A285 Gr.A,B,C; A501, Gr.B; A573, Gr.58,65; A633, Gr.A,C;A711 Gr.1013; API 5 L Gr.BX42, X52</p>					
Typical Composition of all weld metal (wt. - %)					
C	Si	Mn	S	P	
0.07	0.30	0.45	0.020	0.025	
Mechanical Properties of all weld metal					
Heat treatment (PWHT), °C/Hr	Yield strength R _e N/mm ²	Tensile strength R _m N/mm ²	Elongation (L ₀ =4d ₀)	Impact Test Values @ 0°C	
	MPa	MPa	%	J	
As Welded	440	510	23	50	
Operating data					
Position	Polarity	Re-drying/baking conditions:	Ø(mm)	L	Amps
	AC, DCEN DCEP	Applicable only for electrodes exposed to the environment, prior to welding redrying at 100 -110°C for 1 Hr recommended.	2.50	350	60 -90
			3.15	350/450	100-140
			4.00	450	140-180
			5.00	450	180-220
Size & Packaging	Sizes	No. of pcs in Primary packet	No. of packs in outer box	No. of pcs in outer box	
	2.50 x 350	140	6	840	
	3.15 x 350/450	85	6	510	
	4.00 x 450	55	6	330	
	5.00 x 450	35	6	210	
Approvals					
BIS					