

## Shielded Metal Arc Welding

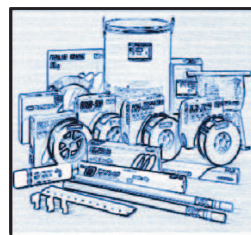
# ANU BOND SPEED (E 6012)

AWS: SFA 5.1, E 6012, IS:814 ER 4112

Mild Steel Welding Electrodes

### **Application :**

Used for welding rusty plates, structural fabrication. Used for tacking works, repair. Construction equipments. Steel furniture, Truck bodies, storage tanks.



### **Characteristics on Usage :**

A general purpose, rutile coated electrode, designed for welding application of structural fabricatoin and repair works. The electrode is running in all position and has medium penetration of welding characteristics, it can be used to weld rusty plates and joints fitup. It produces a flat evenly rippled weld bead, with easily removable slag.

### **Chemical composition of All-Weld metal (%) as per AWS**

| C        | Mn       | Si       | S         | P         |
|----------|----------|----------|-----------|-----------|
| 0.20 Max | 1.20 Max | 1.00 Max | 0.030 Max | 0.030 Max |

### **Mechanical properties of all-weld metal as per AWS**

| UTS                  | Y. S.                | Elongation | Impact                          |
|----------------------|----------------------|------------|---------------------------------|
| (N/mm <sup>2</sup> ) | (N/mm <sup>2</sup> ) | ( L=4d ) % | (CVN) AT +27 <sup>0</sup> C (J) |
| 450 Min              | 350 Min              | 17 % Min   | 50 Joules Min                   |

### **Welding Positions**



### **Packaging & Welding Current**

| SIZE (mm)  | Kg Per Packet | Kg Per Carton | Current (Amps) | In Amps |
|------------|---------------|---------------|----------------|---------|
| 2.50 x 350 | 2.50 Kg       | 12.5 Kg       | AC / DC (-)    | 60-90   |
| 3.15 x 450 | 3 Kg          | 15 Kg         |                | 80-140  |
| 4.00 x 450 | 3 Kg          | 15 Kg         |                | 140-180 |
| 5.00 x 450 | 3 Kg          | 15 Kg         |                | 180-230 |

