

Shielded Metal Arc Welding

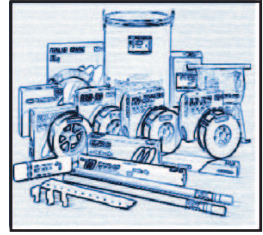
ANU BOND SS(E 6013)

AWS: A 5.1, E 6013 IS: 814 ERR 4222X

Mild Steel Welding Electrodes

Application :

Bridges & Boilers, Compressors, Automobile Part & Fine Steel Furniture, Railway Coaches, Locomotive Fiberboxes, Scooter Frames.



Characteristics on Usage :

A heavy coated all position electrodes for major or minor structures work. The weld metal is radiographic quality, smooth arc, low spatter and medium penetration.

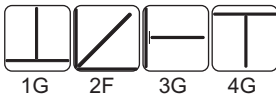
Chemical composition of All-Weld metal (%) as per AWS

C	Mn	Si	S	P
0.12 Max	0.75 Max	0.50 Max	0.030 Max	0.030 Max

Mechanical properties of all-weld metal as per AWS

UTS (N/mm ²)	Y. S. (N/mm ²)	Elongation (L=4d) %	Impact (CVN) at 0 ⁰ C (J)	Radiography Test
400-560 Min	330 Min	19% Min	47 Joules Min	Satisfactory

Welding Positions



Packaging & Welding Current

SIZE (mm)	Pieces Per/ Packet	Pieces Per/ Carton	Current (Amps)	In Amps
2.50 x 350	2.50 Kg	12.50 Kg	AC/ DC (-)	60-90
3.15 x 450	3.15 X 350/450	12.5 / 15 Kg		100-140
4.00 x 450	3 Kg	15Kg		140-190
5.00 x 450	3 Kg	15Kg		190

