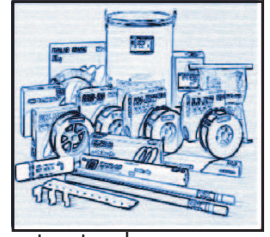


Mild Steel Welding Electrodes

Application :

Ship Building Storage Tanks & Boilers Pressure Pipes Railway Coaches.



Characteristics :

A medium coated rutile type all position electrode with excellent welding characteristics for major structural works where finishing is of importance. Low spatter, smooth arc & easy slag removal, easy to operate in vertical upward position. Ideal where radiographic quality is required.

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

C	Mn	Si	P	S
0.12 Max	0.65 Max	0.40 Max	0.04 Max	0.04 Max

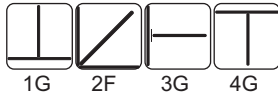
Mechanical properties of all-weld metal as per AWS

UTS (N/mm ²)	YS (N/mm ²)	Elongation (L=4d) %	Impact (CVN) at 0° C (J)	Radiography Test
460-560	370-480 Min	22.0% Min	47 Joules Min	Satisfactory as per IIW blue std

Approvals

BIS

Welding Positions



Packaging & Welding Current

SIZE (mm)	Kgs / Packet	Kg Per Carton	Current (Amps)	In Amps
2.50 x 350	5 Kg	20 Kg	AC/ DC (-)	60- 90
3.15 x 350/450	5 Kg	20 Kg		100- 140
4.00 x 350	5 Kg	20 Kg		140- 190
5.00 x 350	5 Kg	20 Kg		190- 230

