

### CLASSIFICATION

AWS A 5.1	IS 814	BS 639	DIN 1913
E6013	ER4211	E 4322 R11	E 4322 R312

### CHARACTERISTICS

The coating compound in this electrode has rutile and other siliceous materials. These additions of compounds permit the electrodes to operate with AC at low amps and low-OCV. Their flux covering makes slag removal easier and give smooth arc. This is an all position electrode and it operates well on both AC and DC (+/-).

### APPLICATIONS

This type of electrode is used for general purpose welding like ship hulls, tanks, vessels, bridges, railway wagons, steel frames, truck frames and bodies, Ornamental iron, Machinery guards, fertilizer plants and boilers or wherever appearance is important or desirable.

**Note:** Store the Electrode at dry place. For better performance re dry the electrode at 100°C for one hour before use. Clean the weld area thoroughly, free of any contamination.

### WELDING POSITION



1G



2F



3G



4G

### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL

ELEMENT	C	Mn	Si	S	P
PERCENT (max) :	0.10	0.60	0.50	0.035	0.035

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL

YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	Elongation in %	CVN Impact at 0°C (Joules)
410 - 460	460 - 540	22 - 26	50 - 80

### CURRENT CONDITION : AC (OCV – 50V)/ DC (+/-)

SIZE(mm)	Ø 1.60	Ø 2.00	Ø 2.50	Ø 3.20	Ø 4.00	Ø 5.00
CURRENT (amps)	25-40	50 - 75	60 - 90	100 - 140	140 - 180	180 - 230

### PACKING DETAILS

DIA (mm)	Ø 1.60	Ø 2.00	Ø 2.50	Ø 3.20	Ø 4.00	Ø 5.00
LENGTH (mm)	250	300	350	350/450	450	450
WEIGHT /PKT (Kg)	4	4	4	4	4	4
PKT / BOX	5	5	5	5	5	5
WEIGHT /BOX (Kg)	20	20	20	20	20	20