



NORMA



Codification :

AWS SFA 5.1	E6013
IS 814	ER4222
EN ISO 2560-A	E 35 0 R 12



Characteristics & Applications :

A medium coated rutile type AC/DC all position except vertical downward electrode for welding mild steel structures, rail coaches, wagons, storage tanks, ships, sheet metal work etc.

Typical Chemical Composition Of All Weld Metal (%) :

Element	C	Mn	Si	S	P
Typical	0.08	0.44	0.22	0.020	0.020

Typical Mechanical Properties Of All Weld Metal :

Properties	UTS(MPa)	YS(MPa)	%El (L=5d)	CVN Impact Strength (J)
				0°C
Typical	481	436	27	62

Welding Positions :



Current And Packing Data: AC / DC(-)

Size (mm) Dia x Length	5x450	4x450	3.15x350	2.5x350
Current Range (Amps)	180-220	140-180	100-140	60-90
Qty (Pcs/Carton)	65	100	150	260

Approvals :

ABS, Adani Infra, BHEL, BIS, BV, CE, DNV, EIL, Indian Navy, IRS, LRA, NTPC, PDIL