

E-BOND

CLASSIFICATIONS

AWS A/SFA 5.1 E6013
IS 814 E R4121

IDENTIFICATION: Name Printed

CHARACTERISTICS

General purpose all position electrodes for welding Mild Steel and Low Carbon Mn Steel having UTS in the range of 430-540 Mpa. The electrode produces smooth and forceful arc, with low spatter. Weld bead is having uniform ripples with easy deslagging characteristics. Consistent/comparable economy and superior performance.

TYPICAL APPLICATIONS

General structural application where mild steel is used. Storage tanks, railway wagons, pipes, sheet metal work, steel furniture, ship building, vehicles etc. IS:2062 steel or equivalent (Upto 20mm thick).

WELD METAL CHEMISTRY, (%)

| | |
|---------------|--------------|
| C - 0.10 max | S - 0.03 max |
| Mn - 0.2-0.5 | P - 0.03 max |
| Si - 0.30 max | |

MECHANICAL PROPERTIES- ALL-WELD

| Condition | UTS MPa | YS MPa | % Elong. (L=4Xd) | CVN Impacts,J +27 ⁰ C |
|-----------|------------|-----------|---------------------|-------------------------------------|
| As-welded | 430-540 | 370-480 | 22-26 | 40-70 |

APPROVALS

BIS IS 814 E R4121

CURRENT CONDITIONS DC: AC / DC (-)

| | | | |
|---------|---------|---------|-------|
| 5.0 | 4.0 | 3.15 | 2.5 |
| 180-240 | 140-180 | 100-130 | 60-90 |

WELDING POSITIONS

F, H, V-up, OH

REDRYING CONDITIONS

If moist, redry at 90-100° C for 30-60 minutes

PACKING DATA

| | | | | | |
|----------------------------|-----|-----|------|------|-----|
| Dia., mm | 5.0 | 4.0 | 3.15 | 3.15 | 2.5 |
| Length, mm | 450 | 450 | 450 | 350 | 350 |
| Pcs per carton, Nos | 36 | 55 | 85 | 85 | 150 |
| Cartons / box | 6 | 6 | 6 | 6 | 6 |
| Pcs per box, Nos | 216 | 330 | 510 | 510 | 900 |
| Approx. Wt. of 1000 pcs,kg | 87 | 56 | 36 | 29 | 17 |



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ADOR WELDING LIMITED

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