

MAGNABOND

CLASSIFICATIONS

AWS A/SFA 5.1 E6013

IDENTIFICATION: Name Printed

CHARACTERISTICS

Medium rutile coated electrode yielding a moderately quick-setting type of slag. The electrode deposits smooth, radiographic quality weld metal with low spatter. Bead shape is uniform, smooth and slag is easy to remove. Ideal for vertical-down welding of thin plates and horizontal butt joint of large storage tanks.

TYPICAL APPLICATIONS

Storage tanks, all kinds of constructional work, automobile bodies, shipbuilding, bridges, pressure vessels, furniture, sheet metal work and pipes. Suitable for joining steels conforming to ASTM specifications : SA -36 / SA-36M (P.No.1) SA-53/SA-53M (P.No.1) A,B,C,D grades of SA-283/SA-283M (P.No.1)

APPROVALS :

LRA 2m, NR **DNV** Gr-2
ABS Gr-2 **IRS** Gr-2
BV Gr-2

CURRENT CONDITIONS: AC or DC (±)

5.0	4.0	3.20	2.5
150-240	130-190	85-130	60-100

WELDING POSITIONS

F, H, V-up, V-down, OH

REDRYING CONDITIONS

None. Moist electrodes may be reconditioned at 100-110° C for ½ hr.

WELD METAL CHEMISTRY, (%)

C - 0.11 Max Mn - 0.65 Max Si - 0.45 Max
S - 0.03 Max. P - 0.03 Max.

PACKING DATA

Dia., mm	5.0	4.0	3.2	2.5
Length, mm	450	450	450	350
Wt. per carton, kg	5	5	5	5
Cartons / box	4	4	4	4
Net wt per box, kg	20	20	20	20

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS MPa	YS MPa	% Elongation (L = 4xd)	CVN Impacts, J 27+2°C 0°C
As-welded	460-550	360-480	22-30	55-95 47-70



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ADOR WELDING LIMITED

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