

# MAXBOND

## CLASSIFICATIONS

**AWS/SFA 5.1** E6012

**IDENTIFICATION:** Name Printed

## CHARACTERISTICS

A general purpose, rutile type mild steel electrode designed for welding application of structural importance in general fabrications and repair work. The electrode has medium penetration and its ability to bridge wide gaps makes it ideal for poor fit up. Also usable on rusty plates. It produces a flat, evenly rippled weld bead. The slag is quick freezing and easy to remove & hence welder friendly. Easy to operate in all positions. Can be operated on DC (+) also.

## TYPICAL APPLICATIONS

- Steel, furniture, truck bodies storage tanks
- Tacking work, repair of small parts
- Light gauge work, foundry equipment
- Constructions equipment, machinery, barges etc.

### WELD METAL CHEMISTRY (%)

C: 0.12 Max Mn: 0.35-0.55 Si: 0.25 Max  
S: 0.03 Max. P: 0.03 Max.

### MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS MPa	YS MPa	% Elong. (L = 4xd)	CVN Impacts, J 27±2°C
As-welded	430 min	330 min	22 min	47 min

## APPROVALS :

**LRA** 1m, NR      **DNV** Gr-1  
**ABS** Gr-1      **IRS** Gr-1  
**BV** Gr-1

## CURRENT CONDITIONS: AC or DC (-)

5.0      4.0      3.2  
165-260      125-175      95-125

## WELDING POSITIONS

F, H, V-up, OH

## REDRYING CONDITIONS

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

### 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



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