

METALBOND

CLASSIFICATIONS

AWS A/SFA 5.1 E6013
IS 814 E R4112 X

IDENTIFICATION: Name Printed

CHARACTERISTICS

Medium coated rutile type electrode operates on low OCV transformer in all positions including vertical down. Gives medium penetration, least spatter and easily detachable slag. Easy to operate with very good striking and re-striking. Radiographic quality welds.

IDEAL FOR WELDING

Storage tanks, pipes, Machine frames, Construction equipments, Welding mild structural steels like IS:2062, IS:226 etc

WELD METAL CHEMISTRY, (%)

C - 0.12 max. S - 0.03 max.
 Mn - 0.55 max. P - 0.03 max.
 Si - 0.35 max.

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS MPa	YS MPa	% Elong. (L=4Xd)	CNV Impacts, J	
				+27 ⁰ C	0 ⁰ C
As-welded	460-550	370-470	22-28	50-80	30-35

APPROVALS

ABS Gr-1 **LRA** Gr-1
BV Gr-1 **BHEL** E6013
DNV Gr-1 **BIS** E R4112X
IRS Gr-1

CURRENT CONDITIONSDC: AC or DC (-)

4.0	3.2	2.5
140-180	100-130	60-80

WELDING POSITIONS

F, H, V-up, OH

REDRYING CONDITIONS

None. Moist electrodes may be reconditioned at 100-110⁰C for ½ hr

PACKING DATA

	4.0	3.2	3.2	2.5
Dia., mm	4.0	3.2	3.2	2.5
Length, mm	450	450	350	350
Pcs per carton, Nos	91	137	177	296
Cartons / box	4	4	4	4
Pcs per box, Nos	364	548	708	1184
Approx. Wt. of 1000 pcs,kg	54	36	28	17



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ADOR WELDING LIMITED
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