

# SILOX Fe

## CLASSIFICATIONS

**DIN 1913** E4300 A 525  
**IS 814** E S4122

## CURRENT CONDITIONS : AC, DC (-)

5.0 4.0 3.2  
180-220 140-180 90-130

**IDENTIFICATION:** Name Printed

## CHARACTERISTICS

A mild steel electrode to deposit almost pure Iron with low impurities. Weld metal is made resistant to corrosion by molten Zinc. It gives excellent arc stability, fine ripples and very easy slag removal.

## WELDING POSITIONS

F, H, V-Up, OH

## REDRYING CONDITIONS

Not Recommended

## TYPICAL APPLICATIONS

Specially designed for welding and repairing of Hot dip galvanizing baths which calls for electrodes with low Silicon. Filling holes, building up worn out parts not subjected to excessive wear. Ordinary structures e.g. windows, door frames etc.

### WELD METAL CHEMISTRY, (%)

C - 0.08 max. S - 0.03 max.  
Mn - 0.10-0.30 P - 0.03 max.  
Si - 0.03 max.

### PACKING DATA

Dia., mm	5.0	4.0	3.2
Length, mm	450	450	450
Pcs per carton, Nos	52	80	122
Cartons / box	4	4	4
Pcs per box, Nos	208	320	488
Approx. Wt. of 1000 pcs,kg	96	63	41

### MECHANICAL PROPERTIES - ALL-WELD

Condition	UTS MPa	YS MPa	% Elong. (L=4Xd)	CVN Impacts, J 27°C
As-welded	415-520	330-425	22-27	50-80



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**ADOR WELDING LIMITED**

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