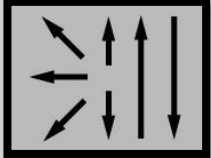



Classification							
AWS A5.1	IS 814						
E 6013	ER 4211						
Features & Benefits							
<ul style="list-style-type: none"> ▪ Excellent weldability in all position thus ease of manipulation & high welder appeal. ▪ Well suited for welding rusty & primed plates thus good penetration & no surface preparation required. ▪ Excellent re-striking and arc stability characteristics and usable on low OCV transformers (OCV~45V) ▪ Good fluidity & excellent passage through joints thus helps easy & controlled flow of weld metal including bad fit-up joints & tack welding. ▪ Typical applications are tanks, ships, trawlers, dredgers, machinery construction, bridges & sheet metal works. 							
Base Material							
IS 2062, IS 2002, A36 Gr. all; A516 Gr.55 to Gr.70, API 5L Gr.B, X42 –X60.							
Typical weld metal analysis (wt.%)							
C	Si	Mn	P	S	Cr	Mo	Ni
0.06	0.30	0.45	0.021	0.020	-	-	-
Mechanical Properties of all weld							
Heat treatment condition	Yield strength	Tensile strength	Elongation (L ₀ = 5d ₀)	Impact Strength 0°C	Hardness		
	MPa	MPa	%	J	BHN		
As Welded	440	520	25	55	< 180		
Operating data							
Position	Polarity	Re-drying/baking conditions:	Ø(mm)	L	Amps		
		Applicable only for electrodes exposed to the environment, prior to welding redrying at 100-150°C for ½-1 Hrs recommended.	2.5	350	80-110		
			3.15	350/450	100-140		
			4.0	450	130-180		
			5.0	450	180-240		
Sizes & Packaging		Size	Kg./Pack	Kg./Box			
		2.5x350	5.0	20.0			
		3.15x350	5.0	20.0			
		4.0x450	5.0	20.0			
		5.0x450	5.0	20.0			
Approvals							
IBR, LRS (applied for)							