



## MILD STEEL SPECIAL ELECTRODES

### PREMIER 6013X WELWELDER 6013X

#### CHARACTERISTICS :

A medium heavy coated, rutile type, general purpose, all position Mild Steel Electrode with good mechanical properties. Yields radiographic quality welds and excellent for sheet metal work

#### APPLICATIONS :

Heavy structural steel work, Ships, Boilers, Pressure pipelines, Oil tanks, Sheet metal welding etc.

#### TYPICAL WELDMETAL COMPOSITION :

Element	Percent
C	0.068
Mn	0.50
Si	0.23
P	0.025
S	0.020

#### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

Ultimate Tensile Strength Kg/mm <sup>2</sup>	Yield Strength Kg/mm <sup>2</sup>	Elongation % (L=5d)	CVN Impact Strength at 0 °C. Kgm
55	49	26	8

#### CLASSIFICATION :

AWS A5.1	:	E 6013
IS	:	ER 4322 X
DIN 1913	:	E 4322 R 3
BS 639	:	E 4322 R

#### CURRENT RANGE & PACKING DATA :

Size MM DxL	Current Range (Amps) AC or DC (-)	Pieces per Packet	Pieces per Carton
6.30x450	240-320	40	160
5.00x450	160-240	55	220
4.00x450	120-150	85	340
3.15x450	80-100	130	520
3.15x350	80-120	130	520
2.50x350	60-80	225	900
2.00x350	30-60	340	1360

Or, 5Kg per Packet and 4 Packets per Carton.

### Approved By:

**Lloyds Register of Shipping (LRS)  
American Bureau of Shipping (ABS)  
Bureau Veritas (BV)**

### WELWELDER 6013XX

#### CHARACTERISTICS :

A heavy coated, rutile type, all position general purpose electrode for radiographic quality welds at high welding speed. A very soft arc, medium penetration, uniform, smooth and shiny bead with self peeling slag.

#### APPLICATIONS :

Pressure vessels, Boilers, Locomotive fire boxes, Scooter frames, Heavy girder fabrication, Bridges, Cranes, Machinery base, Storage tanks and where strength combined with finish is necessary.

#### TYPICAL WELDMETAL COMPOSITION :

Element	Percent
C	0.075
Mn	0.55
Si	0.28
P	0.027
S	0.022

#### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

Ultimate Tensile Strength Kg/mm <sup>2</sup>	Yield Strength Kg/mm <sup>2</sup>	Elongation % (L=5d)	CVN Impact Strength at 0 °C. Kgm
56	49	28	8.5

#### CLASSIFICATION :

AWS A5.1	:	E 6013
IS	:	E RR 4322 X
DIN 1913	:	E 4322 RR 6
BS 639	:	E 4322 RR

#### CURRENT RANGE & PACKING DATA :

Size MM DxL	Current Range (Amps) AC or DC (-)	Pieces per Packet	Pieces per Carton
6.30x450	250-320	35	140
5.00x450	190-260	40	160
4.00x450	140-220	65	260
3.15x450	100-140	105	420
2.50x350	60-100	175	700
2.00x350	40-60	290	1160





## MILD STEEL HIGH EFFICIENCY ELECTRODES

### DEEPWELD

#### CHARACTERISTICS :

A heavy coated, iron powder, deep penetration electrode for butt & fillet welds. Steels up to 14 mm thickness can be welded without edge preparation of bevelling. To achieve production targets electrodes can be used at higher current and faster speed.

Deposition efficiency approx. 103%. Can be used only in flat and horizontal position. The deposited weldmetal is of Radiographic quality.

#### APPLICATIONS:

Welding of Heavy structures, Bridges, Tanks, Shipdeck plates by deep penetration technique thus eliminating beveling and refilling of the groove. Penetration beyond the root for depositing fillet weld.

#### TYPICAL WELDMETAL COMPOSITION :

Element	Percent
C	0.06-0.10
Mn	0.45-0.75
Si	0.45-0.65
P	0.03 Max
S	0.03 Max

#### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

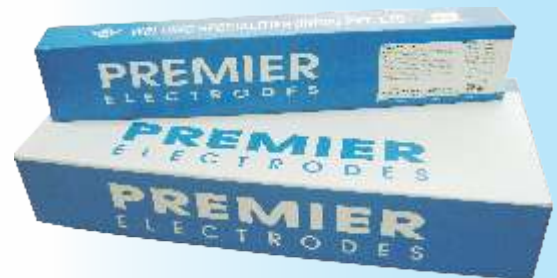
Ultimate Tensile Strength Kg/mm2	Yield Strength Kg/mm2	Elongation % (L=5d)	CVN Impact Strength at 0 °C. Kgm
46-55	37-46	26-28	7-9

#### CLASSIFICATION :

AWS A5.1	:	E 6027
DIN 1913	:	E 4152 AR 11 105
BS 639	:	E 4152 AR

#### CURRENT RANGE & PACKING DATA :

Size MM DxL	Current Range (Amps) AC or DC (-)	Pieces per Packet	Pieces per Carton
5.00x350	250-300	40	160
4.00x350	180-250	65	260
3.15x350	150-180	105	420



### SUPREMO-7014

#### CHARACTERISTICS :

A heavy coated rutile based iron powder electrode. Deposition efficiency is above 110%. The electrode is suitable for all positions including vertical down. Excellent for contact welding. The weld metal is extremely ductile and is of radiographic quality. Also suitable for low alloy medium tensile steels.

#### APPLICATIONS:

Highly stressed structures, High pressure vessels, Boilers, Bridges, Machine parts, Bogies and under frames of Railway wagons, Cranes, Low alloy steels, Steel castings etc.

#### TYPICAL WELDMETAL COMPOSITION :

Element	Percent
C	0.07-0.10
Mn	0.40-0.65
Si	0.15-0.40
P	0.03 Max
S	0.03 Max

#### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

Ultimate Tensile Strength Kg/mm2	Yield Strength Kg/mm2	Elongation % (L=5d)	CVN Impact Strength at 0 °C. Kgm
51-61	41-51	22-26	6-10

#### CLASSIFICATION :

AWS A5.1	:	E 7014
DIN 1913	:	E 5122 RR 11 110
BS 639	:	E 5122 RR

#### CURRENT RANGE & PACKING DATA :

Size MM DxL	Current Range (Amps) AC or DC (-)	Pieces per Packet	Pieces per Carton
6.30x450	260-300	30	120
5.00x450	200-250	45	180
4.00x450	140-200	75	300
3.15x450	100-140	110	440

