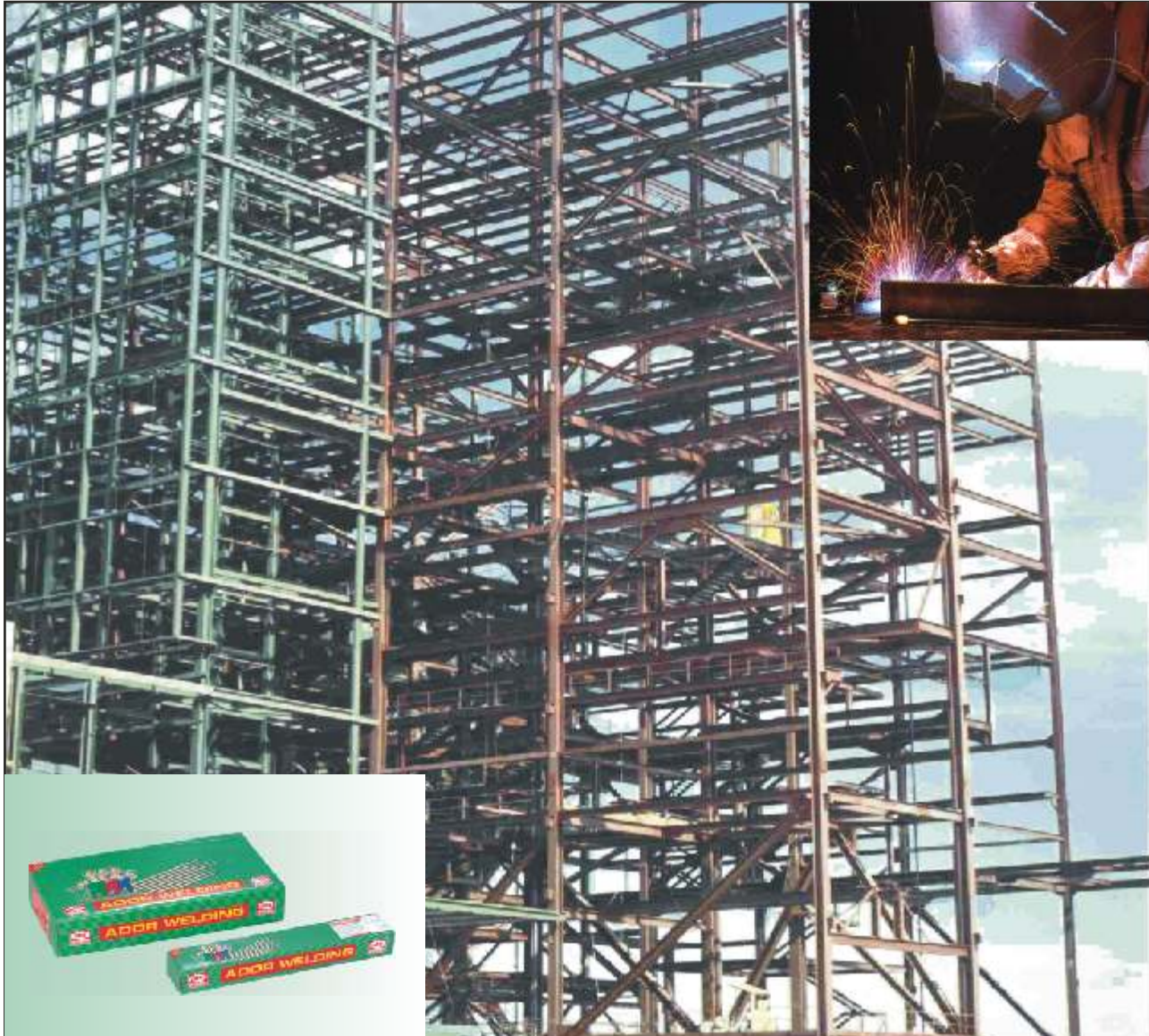


# MAGNABOND

Medium Rutile Coated Electrode



- Medium rutile coated electrode yielding a moderately quick-setting type of slag.
- All position electrode, including vertical-down, makes it easy to weld with.
- The electrode deposits smooth, radiographic quality weld metal with low spatter. Bead shape is uniform, smooth and slag is easy to remove.
- Ideal for vertical-down welding of thin plates and horizontal butt joint of large storage tanks.



**ADOR WELDING LIMITED**  
Central Marketing Office

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# MAGNABOND

Medium Rutile Coated Electrode

## CLASSIFICATIONS

AWS A / SFA 5.1 - E 6013

BS 639 - E 4322 R15

IS 814 ER 4212X

DIN 1913 - E 4322 R3

ISO 2560 - E 432 R15

## APPROVALS

LRS, ABS, BV, DNV, IRS

## IDENTIFICATION

Name Printed

Current Conditions : AC or DC (-)

## CHARACTERISTICS

Medium rutile coated electrode yielding a moderately quick-setting type of slag. All position electrode, including vertical-down, makes it easy to weld with. The electrode deposits smooth, radiographic quality weld metal with low spatter. Bead shape is uniform, smooth and slag is easy to remove. Ideal for vertical-down welding of thin plates and horizontal butt joint of large storage tanks. Re-drying Data: Temperature range : 100-110°C

## TYPICAL APPLICATIONS

Storage tanks, all kinds of constructional work, automobile bodies, shipbuilding, bridges, pressure vessels, furniture, sheet metal works and pipes. Suitable for joining steels conforming to ASTM specifications:

SA-36/SA-36M (P.nO.1) SA-53/SA-53M (P.nO.1) A, B, C, D grades of SA-283/SA-283M (P.No.1)

## WELDING CURRENT (AMP)

5 mm	4 mm	3.20 mm	2.5 mm
150-240	130-190	85-130	60-100

## ALL WELD METAL CHEMISTRY (%)

C : 0.11 max	Mn : 0.65 max	Si : 0.45 max
S : 0.03 max	P : 0.03 max	

## ALL-WELD MECHANICAL PROPERTIES

	N/mm <sup>2</sup>	CVN Impact Value	
UTS	460-550	Temp °C	J
YS	360-480	27+2	55-95
Elong.% (L=4 x d)	22-30	0	47-70

## PACKING SPECIFICATIONS

Dia.mm	5.0	4.0	3.20	2.50
Length, mm	450	450	450	350
Wt.per carton, kgs	5	5	5	5
Carton / box	4	4	4	4
Wt.per box, kgs.	20	20	20	20

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