

METALBOND-S

Rutile Electrode with higher deposition efficiency



- A medium heavy rutile coated all position electrode for structural welding applications.
- The electrode operates on DC(+) as well as DC(-) and AC (50 OCV) also.
- Deposition efficiency is a approximately 8 - 10% higher in comparison to other rutile coated electrodes of E-6013 class which results in 10% more welds length in a fillet.
- The electrode produces a smooth arc, with minium spatter, shiny bead and finely rippled.
- The slag is extremely easy to remove.
- The electrode is suitable for welding in all positions including vertical down fillets.
- Electrodes gives weld metal of radiographic quality.



ADOR WELDING LIMITED
Central Marketing Office

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Rutile Electrode with higher deposition efficiency

CLASSIFICATIONS

BS 639 - E 4322R21 AWS/SFA 5.1 E6013 IS 814 ER 4211X DIN 1913 - E4322R322

APPROVALS

LRS, ABS, BV, DNV, IRS

IDENTIFICATION

Name Printed Current Conditions : AC / DC (+) or (-)

CHARACTERISTICS

A medium heavy rutile coated all position electrode for structural welding applications. The electrode operates on DC(+) as well as on DC (-) and AC (50 OCV). Deposition efficiency is approximately 8-10% higher in comparison to other rutile coated electrodes of E 6013 type. Hence, in fillet welds, total length of the fillet is about 10% more. The electrode produces a smooth arc, minimal spatter and the slag is extremely easy to remove. The bead is shiny and finely rippled. Suitable for welding in all-positions including vertical down fillets. Gives weld metal of radiographic quality. Redrying Data : Temperature range - 100-110°C

TYPICAL APPLICATIONS

- Storage tanks, automobile bodies, bus bodies
- L.P.G. Cylinders, pipes & tubes
- Railway coach panels, galvanised sheets
- Shipbuilding
- Bridge structures, pressure vessel
- Steel furniture and sheet metal work

WELDING CURRENT (AMPS)

5.00 mm	4.00 mm	3.20 mm	2.50 mm
180-250	140-190	100-140	60-90

ALL WELD METAL CHEMISTRY (%)

C : 0.10 max	Mn : 0.60 max	Si : 0.35 max
S : 0.03 max	P : 0.03 max	

ALL-WELD MECHANICAL PROPERTIES

	N/mm ²	CVN Impact Value
UTS	460-550	Temp °C J
YS	360-480	0 50-100
Elong. % (L=5 x d)	22-30	
Red in area %	50-75	

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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