



## ADOR SP-6

C-Mn STEEL (Special Purpose)



Mild Steel Special Welding Electrode for Joining of Rails

### KEY FEATURES :

- Basic type electrode
- Radiographic weld deposit
- Suitable for multi-pass welding

### WELDING POSITION :



AC (50 OCV) /DCEP

### TYPICAL APPLICATIONS :

- Butt welding of rails with tensile strength upto 1100 MPa

**REDRYING CONDITION : 250-300°C for minimum 1 hr.**

### CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	S	P
Typical	0.04	1.1	0.4	0.02	0.02
Specification	0.02-0.06	0.6-1.5	0.15-0.65	0.025 max.	0.025 max.

### MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact, J	
					at 20°C	At -20°C
Typical	As Welded	530-630	420-500	24 min	140	95
Specification					120-180	60-120

### PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt. per carton, Kg	Carton/Box	Wt. per box, Kgs
4.0 x 450	160-200	5	4	20
5.0 x 450	180-240	5	4	20