



## SILOX Fe

C-Mn STEEL (Special Purpose)



Electrode for Welding Hot Dip Galvanizing Baths

**CLASSIFICATION : DIN 1913**

**IS 814**

E 4300 A 525

E S4122

### KEY FEATURES :

- Deposit pure iron with low impurities
- Low Silicon content
- Resistant to corrosion by molten Zinc
- Easy slag removal

### WELDING POSITION :



**AC (50 OCV)/ DCEN**

### TYPICAL APPLICATIONS :

- Welding and repairing of hot dip galvanizing baths
- Windows, door frames
- Filling holes, building up worn out parts not subjected to excessive wear

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

	<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>S</b>	<b>P</b>
Typical	0.05	0.15	0.02	0.02	0.02
Specification	0.08 max.	0.10-0.30	0.03 max	0.03 max	0.03 max

### MECHANICAL PROPERTIES OF ALL WELD METAL :

	<b>Condition</b>	<b>UTS, MPa</b>	<b>YS at 0.2% offset, MPa</b>	<b>EL%</b>	<b>CVN Impact at 27°C, J</b>
Typical	As Welded	460	400	25	66
Specification		415-520	330-425	22-27	50-80

### PARAMETERS - PACKING DATA :

<b>Ø x L, mm</b>	<b>Amperage, A</b>	<b>Approx. Pcs/Carton</b>	<b>Carton/Box</b>	<b>Approx. wt. of 1000 pcs, Kg.</b>
3.15 x 450	90-130	122	4	41
4.0 x 450	140-180	80	4	63
5.0 x 450	180-220	52	4	96