

Technical Newsletter from  
**ADOR WELDING LIMITED**  
Formerly **Advani - Oerlikon Ltd.**

## **KINGBOND - KING OF E 6013 ELECTRODES**

### **An Overview**

In a developed economy, per capita consumption of steel is about 300 kg / person / year. When a country is in infrastructure creation mode, the consumption goes up even to 1,000 kg / person / year and finally may stabilize at around 300 kg. The per capita steel consumption reported for China is 220 kg and that for South Korea is as high as 950 kg presently. India's steel consumption is 35 kg / person / year at present. This indicates the potential for growth for steel consumption in our country. In 2010-11, India produced around 78 Million tonnes of steel from both primary and secondary producers. Using the empirical formula of 0.5 kg of weld per ton of steel means 39 million tonnes of weld. Out of these 27 million tonnes of weld would be by manual Metal Arc Welding and the rest by continuous welding. This gives an approximate requirement figure of 40 million tonnes after accounting for stub losses of manual welding electrodes, out of which about 30 million tonnes of General Purpose Mild Steel electrodes and the rest by special purpose electrodes. This gives an indication of the potential for E 6013 electrodes.

### **Why the need for a new E 6013 type of electrode?**

Most of the traditional electrodes available are meant for specific applications – we need to choose correct type depending on the application. Some examples are described below:

## **Product Update**

### **CHAMP Series**

**ador WELDING**  
**Latest Inverters**  
**Smooth & Spatter Less**  
Can weld even with your Kanjivaram on!

**CHAMP SERIES**

- If welding with AC power source is good, then there is no low OCV performance.
- When we get good weld bead finish, then we can not do smooth vertical down welding.
- When there is welder's appeal, then there is no weld toughness.
- If we get good slag detachability then the spatter loss is high.

There was a need to combine many of the above conflicting requirements into one single electrode.

Kingbond has been designed keeping the above points in mind.

#### Kingbond – Special Features:

- It can be operated on AC, DCEP, DCEN i.e. on Transformer, Rectifier & Generator.
- It can also be operated at voltage as low as 55 V OCV - hence even local make transformers can be used for welding Kingbond.
- With very smooth arc, the metal transfer across the arc is smooth. This result in least spatter – more deposit and less work to remove spatter - higher value for money.
- Due to soft arc, poor fit up of edges can be easily managed even in light sheet metals without any defects like burn through, undercuts etc.
- As the arc is very stable, the skill required for the welder is low.
- Fast freezing slag enables easy vertical down welding.
- The “Cup Depth” is less compared to most of the electrodes in this class – this makes the arc re-stricking by short circuit mode much easier – This makes repeated welding of small beads or spot welds so much easier.
- Excellent self peeling slag– less trouble with deslagging resulting in higher productivity and better quality weld.
- The weld bead obtained is fine rippled and smooth - extra surface dressing is not required.
- It is a low fume emitting electrode.

#### KING Series of Gas Cutting Products



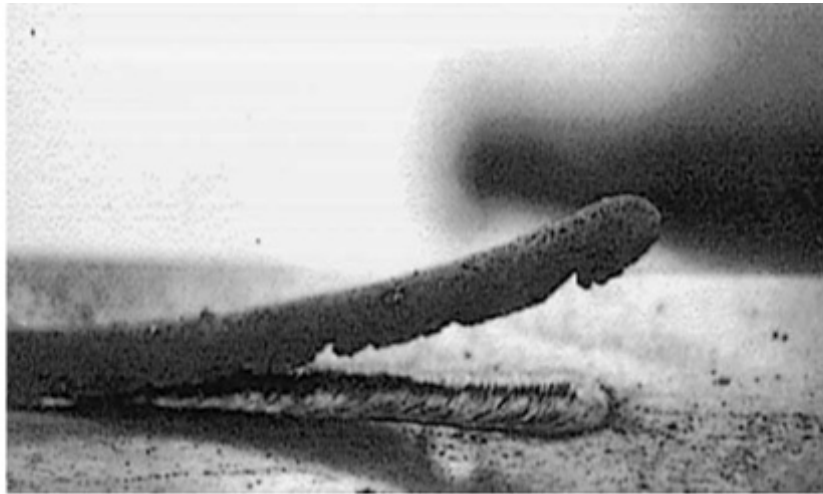
- **KING TIGER**  
Portable Gas Cutting Machine
- **KING JOIN - AGWT / HT-1**  
Gas Heating Torch
- **KING PANTHER**  
Portable Gas Cutting Machine

[read more](#)

#### KING Series of Welding Accessories



- **KING COOL - 600 AMPS -  
Medium Duty**



Self peeling slag



Excellent fusion with base metals provides a longer bead for each electrode - this is advantageous in welding sheet metals.

- KING SWORD - 600 AMPS - Heavy Duty
- HEAVY DUTY EARTHING CLAMP - 600 AMPS
- KING SHIELD- HAND (83 X 108mm)
- KING SHIELD - HEAD
- KING SHIELD - AUTO
- ADOR Welding HAND GLOVES
- ADOR SAFETY FOOTWEAR

[read more](#)

## KINGBOND

KING of E 6013 class of electrodes



- Radiographic Quality Weld
- Comes with BIS certification
- Operates at as low as 50V OCV
- Easy Arc striking / re-striking Toness upto zero degree

[read more](#)

Helpline No.

1 800 233 1071

For Welding &  
Cutting Equipment,  
Service & Spares





Easy vertical down performance.



- The coating is designed to take higher currents without electrode losing its properties – Even with higher currents, we can weld till the end of the electrode, without any weld defects.
- The result is a weld which passes X ray test



#### FREE SERVICE CLINIC

can be arranged on request if you have 25 or more numbers of AWL make welding and cutting equipment at single site/ nearby site. For Further Details Please E-Mail to [cmo@adorians.com](mailto:cmo@adorians.com)

**Service Clinics  
During the Month of  
September 2012**

- M/S JINDAL STEEL WORKS BELLARY – BANGALORE AREA - 36 Nos.
- M/S JUPITOR WAGON LTD BANDEL KOLKATA – KOLKATA AREA - 11 Nos.

**Ador Welding Academy (AWA)**



- We get a weld metal with excellent toughness even at 0°C.

### Quality and Approval

The high quality of Kingbond is approved and certified by BIS with IS 814 – ER4211X classification.

### Applications:

- General fabrication of mild structural steels like IS 2062, 226, ASTM SA 283 etc.
- All kind of light construction work.
- Storage tanks.
- Shipbuilding.
- Sheet metal work, furniture.
- Automobile bodies.
- Pipes.
- Machine frames.
- Truck bodies.
- Construction equipment.
- Railway coach panels.

### Conclusion:

Kingbond electrodes can be used with any welding equipment, using welder of any skill level, in any welding position and in any application involving C-Mn steel of 25mm (max.) thickness to deposit welds that meets radiographic quality and toughness up to 0°C.

To know more about Kingbond and other superior general purpose electrodes, please write to us : [cmo@adorians.com](mailto:cmo@adorians.com) or visit us [www.adorwelding.com](http://www.adorwelding.com)



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# ADOR WELDING LIMITED

(Formerly known as Advani-Oerlikon Limited)



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