

Metalbond SS

MILD STEEL ELECTRODE FOR HIGH SPEED STRUCTURAL WELDING

CLASSIFICATION : AWS A/SFA 5.1 IS 814
E 6013 ERR 4221X

KEY FEATURES :

- ✓ Rutile based heavy coated
- ✓ Touch type electrode
- ✓ X-ray quality weld deposit
- ✓ Suitable for major structural work and bridging wide root gap

WELDING POSITION :



AC (50 OCV)/DCEN

TYPICAL APPLICATIONS :

- ✓ Pressure vessels, Storage tanks
- ✓ Locomotive fireboxes, Boilers
- ✓ Railway coach panels
- ✓ Fine steel furniture
- ✓ Automobile bodies
- ✓ Joining steels like-
ASTM SA 36/36M
SA 283/283M Gr.A/B/C/D
SA285/285M Gr.A/B/C
SA 414/414M Gr.A/B

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt% :

	C	Mn	Si	S	P
Typical	0.06	0.45	0.2	0.02	0.02
Specification	0.20 max	1.20 max	1.0 max	0.03 max	0.03 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at 0°C, J
Typical	As Welded	500	410	25	65
Specification		430 min	330 min	22 min	50 min

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Approx. Pcs/ Carton	Carton/Box	Approx. wt. of 1000 pcs, Kg.
2.0 x 300	40-60	495	4	10
2.5 x 350	60-90	244	4	20
3.15 x 450	100-140	114	4	44
4.0 x 450	140-190	73	4	68
5.0 x 450	190-250	48	4	102



PASSION FOR WELDING SINCE 1951
ADOR WELDING LIMITED
(Formerly Advani-Oerlikon Ltd.)

