

**Applications**

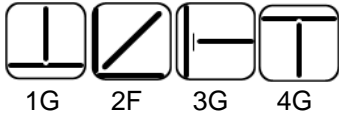
Structures & Building Construction Auto Bodies And Railway Wagons Grills, General Fabrication Vessels, Tanks, Pipelines, Bridges, Ships, Trailers. Building Up Of Shafts, Boilers.

**Characteristics on Usage**

A medium coated all position electrode for work of structural importance with medium penetration, soft arc and low spatter, easy to detach slag. It can be used in both AC & DC.

**Notes On Usage**

- 1) Dry electrode at 70-100 °C for 30-60 min.before use.
- 2) Pay attention not to exceeds the range of proper current.

**Welding Positions****Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%
0.20 Max	1.20 Max	1.0 Max	0.040 Max	0.040Max

**Mechanical Properties Of Weld Metal**

U.T.S.	Y.S.	ELONGATION	IMPACT ( CVN )
(N/mm <sup>2</sup> )	(N/mm <sup>2</sup> )	( L = 4d ) %	AT 0° C
450 Min	350 Min	22 % Min	47 Joules Min

**Approvals**

I.R.S, I.B.R, P.D.I.L., L & T, A.P.G. B.I.S [ISI], M. N. DASTUR & CO,IOCL

**Packing and Welding Current**

SIZE ( mm )	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 x 350	135	810	AC / DC (-)	60 – 90
3.15 x 350	90	540		100 – 140
4.00 x 450	60	360		140 – 180
5.00 x 450	45	270		180 – 230