

SUPERSEAL

IDENTIFICATION: SUPERSEAL, E6013, IS: 814-2004: ER-4211X

CLASSIFICATION: AWS/SFA 5.1: E6013, IS: 814-2004: ER-4211X

CHARACTERISTICS:

Medium coated rutile type, all-position versatile electrode for wide variety of steel fabrication. It has good operability. Deposited weld metal is of radiographic quality.

TYPICAL APPLICATION:

General purpose mild steel fabrication such as plate work, pipes and flanges, tubular section frames, etc. steel furniture and window grill, textile machinery, railway wagons, coaches and trailers, mild steel structures, seat folding etc.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P
0.12 max	0.30-0.55	0.15-0.45	0.03 Max	0.03 Max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	ELN (%) (L=4D)	CVN impact strength	
450 Min	360 Min	22 Min	Temp	Joules
			+27°C	50 Min

Redrying Temp.: 100-120°C for 1 Hr.

RECOMMENDED CURRENT AND PACKING DATA:

Size (mm)	Length (mm)	AMPS AC/DC (+/-)	Packing/Box (Pcs)
2.50	350	60-90	125×6=750
3.15	350	90-130	90×6=540
3.15	450	90-130	90×6=540
4.00	450	130-170	60×6=360
5.00	450	180-220	40×6=240