

MEDIO-S

CODIFICATION: AWS : SFA 5.1 E6013
 IS : 814 ER4322X

CHARACTERISTICS AND APPLICATIONS:

Medio-S is a rutile electrode ideally suited for welding of carbon steels. The weld metal is of radiographic quality and possesses excellent notch toughness at minus 20°C. Typical applications include ship construction, tanks, barges, dredgers, structures, etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	: C	Mn	Si	S	P
Percent	: 0.055	0.55	0.16	0.020	0.020

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS	YS	Elongation	CVN Impact Strength
(MPa)	(MPa)	(L = 4d)%	at minus 20°C (Joules)
485	436	28	50

CURRENT AND PACKING DATA : AC / DC(-)

Size (mm)	: 5x450	4x450	3.15x450	2.5x350
Dia x Length				
Current Range (Amps)	: 190-240	150-180	100-130	60-90
Qty.(Pcs./Carton)	: 50	75	120	180

APPROVAL : Indian Navy