



MEDIO-V

CODIFICATION: AWS : SFA 5.1 E6013
IS : 814 ER4211X

CHARACTERISTICS AND APPLICATIONS:

Medio-V is a medium coated, rutile type, all position electrode. The electrode operates on alternating and direct current either polarity. The weld metal is soft, ductile, metallurgically clean and mechanically sound with radiographic quality. Typical applications include industrial pipes and tubes, storage tanks, boilers, fire boxes tanks, ships, barges, dredgers, trawlers, tugs rail coaches, etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	: C	Mn	Si	S	P
Percent	: 0.08	0.45	0.22	0.018	0.023

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	YS (MPa)	Elongation (L = 4d)%	CVN Impact Strength at 0°C (Joules)
485	440	28.0	60

CURRENT AND PACKING DATA: AC / DC(±)

Size (mm)	: 6.3x450	5x450	4x450	3.15x450	3.15x350	2.5x350
Dia x Length						
Current Range (Amps)	: 260-320	190-250	140-190	100-140	100-140	60-90
Qty. (Pcs./Carton)	: 30	50	75	120	120	180

APPROVAL: BIS