

RAPIDEX

CODIFICATION:

AWS	:	SFA 5.1 E7014
IS	:	814 ES5224JX

CHARACTERISTICS AND APPLICATIONS:

A medium heavy coated, iron powder rutile type electrode suitable for welding all mild steel structures, boilers, pressure vessels. Welds are of radiographic quality. The electrode has a metal recovery of 115 %. Rapidex is suitable for all types of joints to achieve faster speed and higher welding output. Typical applications include boilers, pressure vessels, wagons, girders, tanks, ships, barges, machine parts, etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	: C	Mn	Si	S	P
Percent	: 0.07	0.58	0.24	0.018	0.020

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS	YS	Elongation	CVN Impact Strength
(MPa)	(MPa)	(L= 4d)%	at 0°C (Joules)
515	444	28	60

CURRENT AND PACKING DATA: AC / DC(-)

Size (mm)	:	6.3x450	5x450	4x450	3.15x450	2.5x350
Dia x Length						
Current Range	:	260-340	200-260	160-200	100-150	70-100
(Amps)						
Qty.(Pcs./Carton)	:	25	35	55	75	100