

EXOBEL

CODIFICATION: AWS : SFA 5.1 E6013
 IS : 814 ERR4222X

CHARACTERISTICS AND APPLICATIONS:

A heavy coated rutile type electrode for achieving radiographic quality welds in mild steel boilers, pressure vessels, ships, hull construction, etc. Excellent bead appearance and self peeling slag. Typical applications also include storage tanks, wagons, automobile frames and bodies, rolling stocks, rail coaches locomotive fire boxes, etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	: C	Mn	Si	S	P
Percent	: 0.07	0.46	0.20	0.020	0.020

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS	YS	Elongation	CVN Impact Strength
(MPa)	(MPa)	(L = 4d)%	at 0°C (Joules)
485	444	28	70

CURRENT AND PACKING DATA: AC / DC(-)

Size (mm)	:	6.3x450	5x450	4x450	3.15x450	2.5x350
Dia x Length						
Current Range (Amps)	:	260-320	190-240	140-200	100-135	70-100
Qty.(Pcs./Carton)	:	25	35	55	80	150

APPROVALS: BIS, CIB-MP, EIL, IRS, NPCIL