



## NORMA-V

**CODIFICATION:** AWS : SFA 5.1 E6013  
IS : 814 ER4211

### CHARACTERISTICS AND APPLICATIONS:

A medium coated general purpose all position electrode for welding low carbon and mild structural steels. It gives **radiographic quality** weld metal. The electrode operates with a quiet arc and deposits a smooth bead with fine ripples. The slag is easily detachable. The electrode produces minimum spatter and has good striking and re-striking characteristics. The electrode operates well under low OCV transformers and direct current either polarity. Easy to operate in all positions including vertical down. Typical applications include welding of steel structures, tanks, truck frames and bodies, machinery construction, auto bodies, frames, pipes etc.

### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	C	Mn	Si	S	P
Percent	0.08	0.45	0.25	0.020	0.020

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	YS (MPa)	Elongation (L= 4d)%	CVN Impact Strength at 0°C (Joules)
475	406	24	55

### CURRENT AND PACKING DATA: AC / DC(±)

Size (mm)	5x450	4x450	3.15x350	2.5X350
Dia x Length				
Current Range (Amps)	190-230	140-180	100-140	60-90
Qty.(Pcs./Carton)	40	60	90	150

**APPROVAL:** BIS