



UNITHERME

CODIFICATION: AWS : SFA 5.1 E6020
IS : 814 EA4245X

CHARACTERISTICS AND APPLICATIONS:

Unitherme is an iron oxide type electrode for welding of carbon steels. The welds are radiographic quality. Typical applications include locomotive fire boxes, rotary kilns, heavy structures, engine frames, bases, etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

| | | | | | |
|---------|--------|------|------|-------|-------|
| Element | : C | Mn | Si | S | P |
| Percent | : 0.07 | 0.50 | 0.23 | 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 | 416 | 24 | 50 |

CURRENT AND PACKING DATA: AC / DC(-)

| | | | | | | |
|-------------------------|---|---------|---------|---------|----------|---------|
| Size (mm) | : | 6.3x450 | 5x450 | 4x450 | 3.15x450 | 2.5X350 |
| Dia x Length | : | | | | | |
| Current Range (Amps) | : | 260-350 | 190-260 | 150-210 | 110-150 | 70-100 |
| Qty.(Pcs./Carton) | : | 30 | 45 | 70 | 90 | 125 |

PRECAUTIONS:

1. Redry the electrodes at 125°C for one hour, if necessary.
2. Ensure use of electrode in horizontal and flat positions.