



ISO 9001 | ISO 14001
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BONDS FOREVER

MOHINDERZ ELECTROMELT STANDARD

AWS - E - 6013
IS: 814 - ER - 4211



Mild Steel Electrodes for General Purpose Medium Duty Structural Welding Application

FEATURES

| | |
|--|--|
| Medium Rutile Coated | All Position Welding |
| Excellent penetration & Metal transfer | Faster Freezing Slag for easier positional welding |

APPLICATIONS

Steel Structure / Storage & Pressure Vessels / Pipes / Sheet Metal / Automobile Body / General Fabrication

CHEMICAL COMPOSITION OF WELD METAL (Weight %)

| Metal | Mn | Si | C | S | P |
|----------------------|-------------------|--------------------|--------------------|--------------------|--------------------|
| Specification | 0.4 (Max 0.55) | 0.25 (Max 0.40) | 0.09 (Max 0.12) | 0.02 (Max 0.03) | 0.02 (Max 0.03) |

MECHANICAL PROPERTIES OF WELD METAL

| Property | Metal Condition | UTS (Mpa) | YS at 0.2% (Mpa) | EL % (L = 5D) | CVN Impact at 0°C |
|----------------------|-----------------|-----------|------------------|---------------|--------------------|
| Specification | As Welded | 410-540 | 330-430 | 22-26 % | 55 J (Min 50 J) |

PACKING & WELDING DATA

| Size (Dia mm) | Size (Length mm) | Current (Amp) | Pcs/ Carton Appr. | Carton /Box Appr. | Weight (In Kg) / 100 pcs |
|---------------|------------------|---------------|-------------------|-------------------|--------------------------|
| 2.5 | 350 | 60 - 80 | 131 | 8 | 2 |
| 3.15 | 350 | 100 - 120 | 136 | 5 | 3 |
| 4 | 350 | 120 - 160 | 55 | 8 | 4.5 |
| 4 | 450 | 120 - 160 | 56 | 8 | 6 |
| 5 | 450 | 160 - 240 | 37 | 8 | 9 |



MOHINDERZ

MOHINDER ELECTRODES PVT. LTD.

(Mfrs. & Exporters of Electrodes & MIG Wire)

📍 **Sales Off.:** Plot No. 256, FF, Phase- 9, Industrial Area, S.A.S Nagar, Mohali, Punjab, INDIA-160062

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