



**ISO 9001** | **ISO 14001**  
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**BONDS FOREVER**

# MOHINDERZ GOLD

AWS - E - 6013

IS: 814 - ER - 4211



## Mild Steel Electrodes for General Purpose Structural & Vessel Welding Application

### FEATURES

Medium-Heavy Rutile Coated	All Position Welding
Excellent penetration & Metal transfer	X - Ray quality Weld profile

### 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
<b>Specification</b>	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
<b>Specification</b>	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)

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