



ISO 9001 | **ISO 14001**
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BONDS FOREVER

MOHINDERZ WELSTONE

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



Mild Steel Electrodes for General Purpose Light Welding Application

FEATURES

Medium Rutile Coated	All Position Welding
Low degree of spatter	Smooth weld bead

APPLICATIONS

Steel Furniture / Light Sheet Metal / Scaffolding / Grills / Form Work / General Fabrication

CHEMICAL COMPOSITION OF WELD METAL (Weight %)

Metal	Mn	Si	C	S	P
Specification	0.3 (Max 0.40)	0.20 (Max 0.25)	0.10 (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	440-540	380-440	22-28 %	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
3.1	345	80 - 120	84	8	2.5
3.95	445	120 - 160	59	8	5



MOHINDERZ

MOHINDER ELECTRODES PVT. LTD.

(Mfrs. & Exporters of Electrodes & MIG Wire)

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