



MODI XL 13SS

MILD STEEL ELECTRODE

CLASSIFICATION : IS : 814-2004 : ER 4211 X
AWS/A 5.1 : E 6013

CHARACTERISTICS : A heavy coated rutile type electrode developed for 'TOUCH' type welding. Arc is very stable. Slag removes by itself leaving almost flat and rippleless weld bead. Striking & re-striking is excellent. Weld metal is of radiographic quality and gives excellent mechanical properties.

APPLICATIONS :

- Bung Welding of LPG Cylinder
- Boilers
- Pipe Lines
- Bridges
- Storage Tanks
- Railway Wagons
- Fire Boxes
- Shiphull Constructions

RECOMMENDATIONS : Use proper current. As far as possible use stringer bead technique. Re-dry the moist electrodes at 100°C for minimum 30 minutes.

CHEMICAL ANALYSIS OF WELD METAL (%) :

	C	Mn	Si	S	P
	0.10 max	0.35-0.70	0.40 max	0.035 max	0.035 max

MECHANICAL PROPERTIES OF WELD-METAL (AS PER IS:814-2004) :

	Yield Strength	Ultimate Tensile Strength	Elongation (GL=5d)	Reduction in area	CVN Impact Values at 27°C/0°C
	Kg/mm ²	Kg/mm ²	(%)	(%)	Joules
	44-48	48-56	26-30	50-70	70/50
	N/mm ²	N/mm ²			Kgf.m
	430-470	470-550			7/5

CURRENT CONDITIONS : USE AC(50V) OR DC (±)

Size (mm)	2.5 x 350	3.15 x 450	4.0 x 450	5.0 x 450	6.3 x 450
		3.15 x 350			
Range (Amps.)	70-100	100-130	140-180	190-230	240-280



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