



REKORD

MILD STEEL ELECTRODE

CLASSIFICATION :

IS : 814-2004 : ERR 4221X
AWS/A 5.1 : E 6013

APPROVALS :

BIS, CIB (U.P.), DNV, IRS

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 & restriking is excellent. Weld metal is of RADIOGRAPHIC quality and gives excellent mechanical properties.

APPLICATIONS :

- * Boilers
- * Pipe Lines
- * Bridges
- * Shiphull construction
- * Storage Tanks
- * Railway Wagons
- * Fire boxes
- * Steel furniture etc.

RECOMMENDATIONS :

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

**CHEMICAL ANALYSIS
OF WELD-METAL(%) :**

| C | Mn | Si | S | P |
|---------|-----------|---------|---------|---------|
| 0.10max | 0.40-0.60 | 0.40max | 0.03max | 0.03max |

**MECHANICAL PROP-
ERTIES OF ALL 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 DC (±) OR AC (50V) ONLY

| | | | | | |
|-----------|---------|----------|---------|---------|---------|
| Size (mm) | 2.5x350 | 3.15x450 | 4.0x450 | 5.0x450 | 6.3x450 |
| Amps | 70-100 | 100-130 | 140-180 | 190-230 | 240-280 |

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