



STEELON STANDARD

MILD STEEL ELECTRODE

CLASSIFICATION :

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

APPROVALS :

BVIS	TISCO	BIS	M.N. Dastur, TCE
Lloyd's Register	NTPC	CIB (U.P.)	UHDE
BHEL	IOC	EIL	TOYO
Dalal	NPC	DNV	Desein

Kvaerner Powergas, LANCO

CHARACTERISTICS :

STEELON STANDARD is a medium coated rutile type electrode suitable for all position welding, including vertical downward. Stable arc, moderately fluid slag, finely rippled bead makes the electrodes highly suitable for all welding shops. Weld metal is capable of meeting radiographic quality standard and gives excellent mechanical properties.

APPLICATIONS :

- * Storage Tanks
- * Boilers
- * Railway Wagons
- * Bridges
- * Structural Work
- * Ship-hull Construction
- * Pipe Lines
- * Furniture

RECOMMENDATIONS :

Keep the electrode in dry place. It is always better to redry the electrodes at 100°C for 30 minutes to obtain the best results. Use welding current within recommended range.

CHEMICAL ANALYSIS OF WELD-METAL(%) :

C	Mn	Si	S	P
0.10max	0.35 - 0.60	0.3max	0.03max	0.03max

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

Yield Strength	Ultimate Tensile Strength	Elongation GL=5d (%)	Reduction in Area (%)	CVN Impact Volume(Min)at 27°C/0°C
Kg/mm ²	Kg/mm ²	(%)	(%)	Joules
42-47	46-56	26-30	50-70	70/50
N/mm ²	N/mm ²			Kgf.m
410-460	460-550			7/5

CURRENT CONDITIONS : USE AC OR DC (+)

Size (mm)	2x300	2.5x350	3.15x350 3.15x450	4.0x450	5.0x450	6.3x450
Amps	50-70	70-100	90-120	140-180	180-220	240-280

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