



# STEELON ULTRA

## MILD STEEL ELECTRODE

**CLASSIFICATION :**

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

**APPROVALS :**

EIL	BVIS-Grade-2	BHEL
BIS	CIB(UP)	NTPC
Lloyd's-Grade 2	NPC	DNV
ABS - Grade 2	IRS	TOYO
M.N. Dastur	PDIL	UHDE

**CHARACTERISTICS :**

A rutile type medium-heavy coated electrode specially manufactured for radiographic quality welds. Low spatter, adequate penetration, easy slag removal and finely rippled smooth beads are the special features of STEELON ULTRA electrodes. Mechanical properties are very good and consistent.

**APPLICATIONS :**

- |                   |                 |
|-------------------|-----------------|
| * Railway Boilers | * Fire Boxes    |
| * Ship Building   | * Pipe Lines    |
| * Structural Work | * Storage Tanks |
| * Machine Bases   | * Bridges       |

**RECOMMENDATIONS :**

To obtain best results use welding current within recommended range. Store the electrodes in dry place. Moist electrodes should be redried at 100°C for minimum 30 minutes.

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

C	Mn	Si	S	P
0.10max	0.40-0.65	0.30max	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 Values at 27°C/0°C
Kg/mm <sup>2</sup>	Kg/mm <sup>2</sup>			Joules
42-47	47-56	26-30	50-70	70/50
N/mm <sup>2</sup>	N/mm <sup>2</sup>			Kgf.m.
410-460	460-550			7/5

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

Size (mm)	2.0x300	2.5x350	3.15x350	4.0x350	5.0x450	6.3x450
			3.15x450	4.0x450		
Amps	50-70	70-100	100-130	140-180	180-230	240-280



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