

JACKSUN - 5

MILD STEEL WELDING ELECTRODE

GRADES

AWS/SFA 5.1 E 6013
IS 814 ER 4212

CHARACTERISTICS

A rutile type, medium coated, all position general purpose electrode operates on both AC & DC. The weld metal possesses good mechanical properties and is of radiographic quality. Its noted features include stable arc with easy arc striking and restricking, easily peeling slag with least spatter and smooth welds beads.

APPLICATIONS

Ideal for welding of mild steel, sheet metals, structures, bridges, furnitures, pipe lines, storage tanks, pressure vessels and general repairs and maintenance.

WELD CHEMISTRY

CARBON - 0.20%	CHROMIUM - 0.2%
MANGANESE - 1.20%	NICKEL - 0.3%
SILICON - 1.00%	MOLYBDENUM - 0.3%
PHOSPHORUS - NOT SPECIFIED	VANADIUM - 0.08%
SULFUR - NOT SPECIFIED	

MECHANICAL PROPERTIES

TENSILE STRENGTH (N/mm²) - 410 - 510
YEILD STRENGTH (N/mm²) - 330 MIN.
ELONGATION (L-5d)% - 22 MIN.
CVN IMPACT @ 0°CJ - 47 MIN

WELDING CURRENT

DC(+)(-) / AC 50
* **2.50 mm** - 60 - 90 Amps
* **3.15 mm** - 100 - 140 Amps
* **4.00 mm** - 140 - 190 Amps
* **5.00 mm** - 180 - 240 Amps

PACKING DATA

Size (mm)	1 BOX	1 CARTON
2.5 x 350	135 Pcs	8 Boxes (1080 Pcs)
3.15 x 350	90 Pcs	8 Boxes (720 Pcs)
4 x 450	60/55 Pcs	8 Boxes (480/440 Pcs)
5 x 450	40 Pcs	8 Boxes (320 Pcs)

APPROVALS

**BIS, IBR, BHEL, IRS Gr.2 Y, ABS Gr.2, DNV Gr.2, Ordnance
Factory Medak, Cethar Vessels, APPGCL**

CONTACT

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An ISO 9001 - 2008 Certified Company

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