



NexaWeld[®]

X-101

MILD STEEL ELECTRODE

For All Position General Fabrication

CLASSIFICATION

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

DESCRIPTION

It is a medium coated rutile type electrode for all position welding. The electrode is characterized by smooth and stable arc, low spatter, easy slag removal and fine rippled bead. Weld deposit good chemical and mechanical properties with radiography quality.

APPLICATIONS

Suitable for the general fabrication, storage tanks, structural steels, truck bodies, ship building, pipe etc.

CHEMICAL COMPOSITION %

C	Mn	Si	S	P
0.12 max	0.25-0.55	0.12-0.35	0.03 max	0.03 max

ALL WELD MECHANICAL PROPERTIES

UTS, MPa	YS at 0.2% MPa	EL%	CVN Impact at 0°C, j
450-540	370-480	22-28	50 min

RECOMMENDED CURRENT CHARACTERISTICS : AC/DC (-)

SIZE mm DXL	2.50x350	3.15x350/450	4.00x450	5.00x450	6.30x450
CURRENT (Amps)	60-90	100-140	140-180	180-220	270-320

Packing Specification – Supplied in 5 kgs x 4 Pkts = 20 Kgs