



NexaWeld®

X-102

MILD STEEL ELECTRODE

For Radiographic Quality welding

CLASSIFICATION

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

DESCRIPTION

Medium rutile coated mild steel electrode designed for welding of unalloyed structural steels in all positions including vertical down. The electrode gives smooth radiographic quality weld with low spatter and less smoke. Slag is self detachable and re-striking is excellent.

APPLICATIONS

Suitable for welding of varying thickness of MS plates in different types joints and ship steels, railway wagon, storage tanks, pipelines, pressure vessels and boiler tubes.

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