



NexaWeld®

X-103

HEAVY COATED MILD STEEL ELECTRODE

For Radiographic Quality welding

CLASSIFICATION

AWS A/5.1 E 6013
IS 814 : ER 4222X

DESCRIPTION

A heavy coated rutile type electrode for achieving welds of superior finish and radiographic quality. It gives low spatter and excellent self lifting slag, striking and re-striking are excellent.

APPLICATIONS

Suitable for wagon building, locomotive fabrication, auto components, pipelines and steel furniture. Also suitable for thin steel due its fine droplet transfer etc.

CHEMICAL COMPOSITION %

C	Mn	Si	S	P
0.10 max	0.60 max	0.30 max	0.03 max	0.03 max

ALL WELD MECHANICAL PROPERTIES

UTS, MPa	YS,MPa	EL%	CVN Impact at 0°C,j
460-550	370-480	23-30	50-80

RECOMMENDED CURRENT CHARACTERISTICS : AC/DC (-)

SIZE mm DXL	2.50x350	3.15x350/450	4.00x450	5.00x450	6.30x450
CURRENT (Amps)	60-100	100-140	140-200	190-200	230-340

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