



NexaWeld®

X-104

HIGH DEPOSITION ELECTRODE

For Mild & Medium Tensile Steel

CLASSIFICATION

AWS A/5.1 E 7024
IS 814 : ERR 5242 KX

DESCRIPTION

X-104 is a super heavy coated, iron powder, rutile type electrode with easy operating characteristics. Electrode deposits a radiographic quality smooth, sound and metallurgically clean weld metal at very high current, resulting in higher deposition efficiency in lesser time. Metal recovery exceeds 150%.

APPLICATIONS

The electrode is ideally suited for down hand butt & horizontal fillet welding in mild steel, heavy steel casting, ship building, locomotive, girders, boilers and in heavy fabrication.

CHEMICAL COMPOSITION %

C	Mn	Si	S	P
0.06-0.10	0.40-0.75	0.14-0.35	0.03 max	0.03 max

ALL WELD MECHANICAL PROPERTIES

UTS, MPa	YS, MPa	EL%	CVN Impact at 0°C,j
500-600	420-500	24-28	50-100

RECOMMENDED CURRENT CHARACTERISTICS : AC/DC (-)

SIZE mm DXL	2.50x350	3.15x450	4.00x450	5.00x450	6.30x450
CURRENT (Amps)	80-100	140-170	180-220	230-280	280-320

PRECAUTIONS

In case of moisture pick up, re-dry the electrodes at 100-150°C for one hour before use.

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