

NEXA GT

SPECIAL ELECTRODE

For Welding Galvanizing Bath & Kettle

DESCRIPTION

It is a special purpose electrode specially designed for welding hot -dip galvanizing baths. The weld metal is highly resistant to molten zinc corrosion. Electrode is further characterized by soft arc, easily detachable slag and low spatter.

APPLICATIONS

Typical application include welding galvanizing baths, filling up of worn-out body of galvanizing bath to resist molten zinc corrosion, window frames, thin walled tanks and vessels etc.

CHEMICAL COMPOSITION %

C	Mn	Si	S	P
0.05 max	0.25 max	0.05 max	0.035 max	0.035 max

RECOMMENDED CURRENT CHARACTERISTICS : AC/DC (-)

SIZE mm DXL	3.15x450	4.00x450	5.00x450
CURRENT (Amps)	110-135	160-180	200-240

NEXA 6012

THIN COATED RUTILE TYPE

For General Purpose Welding

CLASSIFICATION

AWS A/5.1 E 6012
IS 814 : ER 4124

DESCRIPTION

A thin coated rutile type general purpose electrode. it has a stable arc. Easy slag removal and finely rippled bead. Gives excellent welding on rusted sheets also.

APPLICATIONS

The electrode is suitable for structural construction works, tanks, pipelines, bridges, railway wagons, ships and boilers etc

CHEMICAL COMPOSITION %

C	Mn	Si	S	P
0.12 max	0.30-0.50	0.30 max	0.03 max	0.03 max

RECOMMENDED CURRENT CHARACTERISTICS : AC/DC (-)

SIZE mm DXL	2.50x350	3.15x450	4.00x450	5.00x450
CURRENT (Amps)	60-90	90-140	140-180	180-220

NEXA 7024

HIGH DEPOSITION ELECTRODE

For Mild & Medium Tensile Steel

CLASSIFICATION

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

DESCRIPTION

It 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

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



PRODUCT PROFILE



Nexa Weld & Flux LLP

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NexaWeld®

MILD STEEL SERIES

NEXA GP

MILD STEEL ELECTRODE For General Purpose Welding

DESCRIPTION

Nexa-GP is a rutile coated general purpose electrode for welding in all positions. It has a low spatter & smoke. The initial strike & restrike is excellent. The slag is easily detached from fillet and butt welds. In most cases it is self-lifting. The weld appearance is excellent.

APPLICATIONS

Suitable for Construction & Furniture works, Structural steel, Storage tanks, Sheet metal works etc.

CHEMICAL COMPOSITION %

C	Mn	Si	S	P
0.12max	0.60max	0.45max	0.03max	0.03max

RECOMMENDED CURRENT CHARACTERISTICS : AC (70 OCV) DC (+)

SIZE mm DxL	2.50x350	3.15x450	4.00x450	5.00x450
CURRENT (Amps)	60-80	90-130	140-180	180-220

NEXA 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

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

NEXA 6013

MILD STEEL ELECTRODE For General Purpose Welding

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

DESCRIPTION

It is a rutile coated electrode for all position welding. It is suitable for general purpose structural steels. Weld deposit good chemical and mechanical properties with X-Ray quality.

APPLICATIONS

Suitable for steel structures, tanks, truck frames and bodies, ships, pipelines, bridges etc

CHEMICAL COMPOSITION %

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

RECOMMENDED CURRENT CHARACTERISTICS : AC/DC (-)

SIZE mm DXL	2.50x350	3.15x350/450	4.00x450	5.00x450
CURRENT (Amps)	60-90	100-130	140-180	180-240

NEXA 6013 S

MILD STEEL ELECTRODE For Radiographic Quality welding

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

DESCRIPTION

It is a rutile type medium coated electrode for all position welding. It is suitable for all position capability. Weld deposit good chemical and mechanical properties with X-Ray quality.

APPLICATIONS

Suitable for welding of Boiler tubes, Storage tanks, railway wagons, Ship building, bridges, pressure vessels etc.

CHEMICAL COMPOSITION %

C	Mn	Si	S	P
0.10max	0.60max	0.25max	0.03max	0.03max

RECOMMENDED CURRENT CHARACTERISTICS : AC/DC (-)

SIZE mm DXL	2.50x350	3.15x350/450	4.00x450	5.00x450
CURRENT (Amps)	60-90	100-140	140-190	180-250

NEXA XL

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

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

NEXA 6013 SS

HEAVY COATED MILD STEEL ELECTRODE For Radiographic Quality welding

CLASSIFICATION
AWS A/5.1 E 6013
IS 814 : ERR 4211X

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

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