

## A rutile coated general-purpose electrode for MMAW

Classification AWS A5.1: E 6013  
IS: 814 ERR 4221X



### DESCRIPTION

ESAB VORDIAN is an all position medium heavy rutile coated mild steel welding electrode of outstanding quality permitting use of low open circuit voltages. Since it can be touch welded, very little skill is required in obtaining quality welds. ESAB VORDIAN is extremely suitable for flat and horizontal-vertical position as well as for vertical and overhead welding. Excellent welding performance and mechanical properties with radiographic soundness is easily achievable. ESAB VORDIAN is also suitable for pipe welding jobs.

### APPROVALS

ABSGr.2, BIS, BV Gr.2, CIB, DNV Gr.2, EIL, IRS Gr.2, LRS Gr.2, MMD, PDIIIL, RDSO C2.

**WELDING CURRENT:** DC $\pm$ , AC 50V

### TYPICAL APPLICATIONS

ESAB VORDIAN is recommended for applications such as boiler and pressure vessels, bogies and under frame of railway carriages and wagons, bridges and dam construction, cranes, machine building, plate & sheet metal fabrication, ship construction, framework, tanks etc.

### TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.07	Mn	0.42	YS	410 N/mm <sup>2</sup>
Si	0.22	S	0.02	UTS	490 N/mm <sup>2</sup>
P	0.02			EL (L=5d)	26%
				Impact (CVN) at 0°C	90J

### CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	50-105	160	640
3.15	350	85-130	110	440
3.15	450	85-130	110	440
4.00	450	130-180	75	300
5.00	450	160-240	50	200
6.30	450	195-300	30	120

PACKING: Electrodes are packed in cartons and four of these cartons are shrink wrapped in a cardboard box.