

A rutile coated general-purpose electrode for MMAW

Classification AWS A5.1: E 6013
IS: 814 ER 4224X



DESCRIPTION

ESAB VORTIC is a medium coated general-purpose mild steel electrode, especially designed for use in vertical and over head positions. This is a rutile coated, fast freezing slag type electrode with excellent slag detachability even in deep grooves. ESAB VORTIC is characterised by superior running characteristic and exceptionally low spatter, fine rippled weld bead deposit.

APPROVALS

BIS, CIB, IRS Gr.2, LRS Gr.2, MMD, RDSO C1.

WELDING CURRENT: DC±, AC 50V

TYPICAL APPLICATIONS

ESAB VORTIC is recommended for applications such as bogies and under frames of railway carriages and wagons, boilers and pressure vessels, general engineering constructions, pipe welding, sheet metal fabrications, ship construction steel structures and frameworks, tanks and coaches, truck & bus frames and bodies etc.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.07	Mn	0.38	YS	430 N/mm ²
Si	0.17	S	0.025	UTS	490 N/mm ²
P	0.025			EL (L=5d)	26%
				Impact (CVN) at 0°C	65J

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.5	350	40-100	185	740
3.15	450	100-125	125	500
4.00	450	135-175	90	360
5.00	450	150-260	60	240
6.30	450	195-360	35	140

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