

VALIANT

VALIANTWELD - SS

AWS : A5.1 : E 6013 IS : ER 4222 X

Valiantweld - SS is a heavy coated, rutile type electrodes for achieving radiographic quality welds in mild steel boilers, pressure vessels, ships, hull construction etc. Excellent bead appearance and self peeling slag.

CHEMICAL COMPOSITION

C	Mn	Si	S	P
0.10	0.65	0.25	0.03	0.03

MECHANICAL PROPERTIES

UTS (Kg/mm ²)	YS (Kg/mm ²)	EI (L = 4D)%	CVN Impac strength at (Joules) 0°c
47.5	44.4	28	65 J

WELDING PARAMETERS

	Size (mm)	Current (Amp.)
AC/DC (-)	6.30 X 450	260-320
	5.00 X 450	190-240
	4.00 X 450	140-200
	3.15 X 450	100-135
	2.50 X 350	70-100

APPLICATION

Typical applications includes storage tanks, wagons, automobiles frames and bodies, boilers rolling stocks, rail coaches, locomotive fire boxes etc.

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