

EUDUR-110

MEDIUM HEAVY COATED RUTILE-IRON TYPE

CODING: AWS A 5.1/91 – E 7014
IS 814/91 – ES – 5224-JX

CHARACTERISTICS :

EUDUR-110 is a rutile-iron based, medium-heavy coated electrode which produces a fine rippled bead and radio-graphic welds with 115% weld metal recovery. The electrode produces a smooth and stable arc and it is easy to strike and re-strike.

ADVANTAGES :

- Uniform metal transfer with fine rippled bead.
- Easy to control weld pool and slag in position welding.
- Suitable for either polarity in DC (\pm) and in AC
- Smooth and stable arc
- Defect-free and radio-graphic quality weld metal
- Increased metal recovery upto 140%
- Can be used as a TOUCH WELDING TYPE electrode.

APPLICATIONS :

EUDUR-110 is ideally suitable for welding mild steel sections to achieve high metal recovery. Other applications include structural welding of medium to heavy mild steel structures, construction and erection of boilers, pressure vessels, wagons, girders, tanks, ships, brages, coaches, automobile body building etc.,

CURRENT CONDITIONS:

SIZE mm		3.15 X 450	4.00 X 450	5.00 X 450
CURRENT-Amps	AC70 / DC(\pm)	90-120	130-160	160-200

TYPICAL CHEMICAL COMPOSITION OF WELD METAL

Element	C	Mn	Si	S	P
percent	0.07	0.60	0.22	0.020	0.020

TYPICAL MECHANICAL PROPERTIES OF THE WELD METAL

Y.S. N/sq mm.	UTS N/sq mm	% Elongation	% Redn. In area	CVN Impact value
420	530	25	70	70 J

RADIOGRAPHIC EVALUATION : GRADE-I - SATISFACTORY

METAL RECOVERY : 115% approx.

REBAKING RECOMMENDATIONS : If the electrodes are found to be wet/with moisture rebake the electrodes at 125°C for one hour before use.