HEAVY COATED RUTILE–IRON TYPE

EUDUR-140

CODING: AWS A 5.1– E 7024

CHARACTERISTICS :

EUDUR-140 is a rutile-iron based, super-heavy coated electrode which produces a fine rippled bead and radio-graphic welds with 140% weld metal recovery. The electrode produces a smooth and stable arc and it is easy to strike and re-strike. With high current high speed welding is possible in flat and horizontal welding positions.

ADVANTAGES :

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

APPLICATIONS :

EUDUR-140 is ideally suitable for welding mild steel sections where high speed welding with faster speed are required. Due to this welding is economical. Other applications include heavy structures, column bases, bridges, ship and vessel constructions, locomotives, girders, tankers, heat exchangers, boilers etc., The electrode is suitable for carbon steels, low alloy steels, steels of grade ST-33, ST-42, ST-46 and ST-52.

CURRENT CONDITIONS:

SIZE mm		3.15 X 450	4.00 X 450	5.00 X 450
CURRENT-Amps	AC 70 /DC(±)	120-160	170-220	240-280

TYPICAL CHEMICAL COMPOSITION OF WELD METAL

Element	C	Mn	Si	S	P
percent	0.09	0.70	0.30	0.020	0.020

TYPICAL MECHANICAL PROPERTIES OF THE WELD METAL

Y.S. N/sq mm.	UTS N/sq mm	% Elongation	CVN Impact value at 0°C
430	510	22	47 J

RADIOGRAPHIC EVALUATION : GRADE-I - SATISFACTORY
REBAKING RECOMMENDATIONS : Rebake the electrodes at 250°C for one hour before use.