

HEAVY COATED RUTILE TYPE GENERAL PURPOSE ELECTRODE

EURO FUSE

CODING: AWS/SFA-5.1 E 6013
EN 499 E42 0 RR 12

CHARACTERISTICS :

EURO FUSE is a rutile based, heavy coated general purpose electrode suitable for welding mild steels. The superb and controlled flux formulation ensures excellent performance of the electrode in AC/DC(±) in all welding positions except vertical down. With its soft, forceful & steady arc, easy slag detachability, fine rippled & shiny bead. The weld metal is free from defects and is of radiographic quality.

ADVANTAGES :

- Uniform metal transfer
- Easy to control weld pool and slag in position welding.
- Suitable for either polarity in DC and in AC
- Smooth and stable arc
- Defect-free weld metal

APPLICATIONS :

EURO FUSE is suitable for all sorts of joining, repairing and fabrication of structural works in mild steels. The applications include; welding of Structures, bridges, automobile bodies, automobile parts, machinery fabrication, ships, tugs, barges, trawlers, dredgers, storage tanks, boilers, containers etc.,

CURRENT CONDITIONS:

SIZE mm		2.50 X 350	3.25 X 350 X 450	4.00 X 450	5.00 X 450
CURRENT-Amps	AC50/DC(±)	70-100	100-135	140-200	190-220

TYPICAL CHEMICAL COMPOSITION OF WELD METAL

Element	C	Mn	Si	S	P
percent	0.07	0.45	0.22	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
420	500	25	60 J

RADIOGRAPHIC EVALUATION : GRADE-II - SATISFACTORY