

RUTILE TYPE GENERAL PURPOSE ELECTRODE

NUMBER ONE GOLD

CODING: AWS/SFA-5.1 E 6013
ISO 2560 E43 3 R 12

CHARACTERISTICS :

NUMBER ONE GOLD is a rutile based, medium coated general purpose electrode suitable for flawless radiographic quality welding in mild steel structures. The superb performance of the electrode is ensured by well designed formulation which assists the excellent performance of the electrode in AC/DC(±) in all welding positions. With its soft, forceful & steady arc, easy slag detachability, fine rippled & shiny bead, neat weld profile in fillet welds and characteristics like all position-maneuverability make **NUMBER ONE GOLD** a trust-worthy electrode.

ADVANTAGES :

- Uniform and defect-free metal transfer
- Easy to control weld pool and slag in all positions.
- Suitable for either polarity in DC and in AC with OCV as low as 45V.
- Takes care of poor fit-up joints and fills wider gaps with superior quality weld.
- Usability as a touch type electrode.

APPLICATIONS :

NUMBER ONE GOLD is suitable for all sorts of joining, repairing and fabrication of structural works in mild steels, sheets, structures etc.,. The wide applications of this electrode include; welding of Structures, bridges, automobile bodies, automobile parts, machinery fabrication, steel furnitures, railway coaches & wagons, ships, tugs, barges, trawlers, dredgers, storage tanks, boilers, pipelines, grills 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	AC/DC(±)	70-100	100-140	140-180	180-240

TYPICAL CHEMICAL COMPOSITION OF WELD METAL

Element	C	Mn	Si	S	P
percent	0.06	0.45	0.20	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
390	470	26	76 J