

**CODING:** AWS/SFA-5.1 – E 6012

**NUMBER ONE PLUS**

**CHARACTERISTICS :**

**NUMBER ONE PLUS** is a general purpose mild steel electrode suitable for welding mild carbon steels & low carbon steels for structural and general fabrication work. The electrode possesses excellent operating characteristics.

**ADVANTAGES :**

- Uniform metal transfer
- Easy to control weld pool and slag in all positions.
- Suitable for straight 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.
- **NUMBER ONE PLUS** can be used as a touch electrode.

**APPLICATIONS :**

**NUMBER ONE PLUS** 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, 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	4.00 X 450	5.00 X 450
CURRENT- Amps	AC 50/DC(-)	60-90	100-140	140-180	180-230

**TYPICAL CHEMICAL COMPOSITION OF WELD METAL**

Element	C	Mn	Si
percent	0.08	0.42	0.23

**TYPICAL MECHANICAL PROPERTIES OF THE WELD METAL**

Y.S. Kg/sq mm.	UTS Kg/sq mm	% Elongation	CVN Impact value At 0°C
40	46	24	70 J