

CODING: AWS/SFA-5.1 – E 6013

NUMBER ONE

CHARACTERISTICS :

NUMBER ONE is a rutile based, medium 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. With its soft, forceful & steady arc, easy slag detachability, fine rippled & shiny bead, and characteristics like easy maneuverability in all positions make **NUMBER ONE** a welder-friendly electrode.

ADVANTAGES :

- Uniform 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.
- **NUMBER ONE** can be used as a touch electrode.

APPLICATIONS :

NUMBER ONE 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 X 450	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	S	P
percent	0.07	0.44	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
390	460	24	70 J