

GM HITECH 60

Classification:

AWS/A 5.1: E6013

IS 814-2004 : ER 4211X

Description:

Rutile Cellulosic type medium coated mild steel universal electrode with very easy to handle at versatile applications. Excellent weldability, very low spatters, smooth arc, fine ripples, self-slag removal, good strike and re-strike. Welds are of radiographic quality.

Applications:

- ❖ Ship building
- ❖ Boiler tank fabrication.
- ❖ Pipeline construction
- ❖ Structure and construction work
- ❖ Automobile bodies, Sheet metal work
- ❖ Railway wagons etc.

Chemical Composition of Weld Metal (WT. %):

C	Mn	Si	S	P
0.10 Max	0.25 – 0.55	0.60 Max	0.040 Max	0.040 Max

Mechanical Properties of Weld Metal:

Tensile Strength (N/mm ²)	Yield Strength (N/mm ²)	Elongation, L=4d (%)	Charpy Impact Value (Joules)
410 - 540	330 Min	22 Min	47 Joules Min at 0°C

Current Conditions: AC (50 OCV) / DC (+)

Size (mm)	2.50 X 350	3.20 X 350/450	4.00 X 350/450	5.00 X 350/450
Current (Amps)	70 - 90	90 - 130	140 - 180	180 - 230

Welding Positions: F, H, V-up, OH

Recommendation:

Ensure the electrodes are dry. Re-dry the moist electrodes at 105° C for one hour to obtain the best results. Use electrodes within recommended current conditions.

Caution:

Protect yourself and others. Fumes & gases can be dangerous to health. Arc rays can injure eyes and burn skin. Electric shock can kill. Refer American National Standard Z49.1 "Safety in welding and cutting".

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