

ESAB VORDIAN

A rutile coated high productivity electrode for SMAW

Classification AWS A5.1: E6013
IS 814: ERR4221X

DESCRIPTION

ESAB VORDIAN is an all position medium heavy rutile coated mild steel welding electrode of outstanding quality permitting the use of low open circuit voltages. ESAB VORDIAN is extremely suitable for flat and horizontal-vertical positions, as well as for vertical and overhead welding.

APPROVALS: ABS, BV, DNV, IBR, IRS, LRS, MMD & TOYO

WELDING CURRENT: DC_±, AC 50V

TYPICAL PROPERTIES

Weld Metal Composition (Wt.%)		All Weld Mechanical Properties	
C	0.07	YS (N/mm ²)	430
Si	0.20	UTS (N/mm ²)	490
Mn	0.35	Elongation (%)	29
		Impact (CVN) @ 0°C (Joules)	90

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	50-80	160	640
3.15	350	60-130	110	440
3.15	450	60-110	110	440
4.00	450	90-170	75	300
5.00	450	130-240	50	200

PACKING: Electrodes are packed in cartons and four of these cartons are shrink wrapped in a cardboard box.