

# ESAB VORTIC

A rutile coated general-purpose electrode for SMAW

Classification AWS A5.1: E6013  
IS 814: ER4224X

## DESCRIPTION

ESAB VORTIC is a medium coated general purpose mild steel electrode, especially designed for use in vertical and over head positions. This is a rutile coated electrode, with fast freezing slag and excellent slag detachability even in deep grooves.

**APPROVALS:** IBR, IRS, LRS & MMD

**WELDING CURRENT:** DC<sub>+</sub>, AC 70V

## TYPICAL PROPERTIES

Weld Metal Composition (Wt.%)		All Weld Mechanical Properties	
C	0.07	YS (N/mm <sup>2</sup> )	430
Si	0.18	UTS (N/mm <sup>2</sup> )	470
Mn	0.40	Elongation (%)	25
		Impact (CVN) @ 0°C (Joules)	70

## CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	40-100	185	740
3.15	450	100-125	125	500
4.00	450	135-175	90	360
5.00	450	150-260	60	240

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