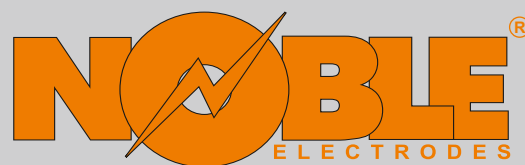


NOBLE - MS

Mild Steel General Purpose Electrodes



CLASSIFICATION

IS - 814:2004: ER 4111
IRS - GRADE - 2

AWS - A 5.1: E6013
CWB - W48-18: E4313

Characteristics : NOBLE - MS is a medium coated Rutile type all position general purpose electrode which gives uniform deposition, smooth arc characteristics and good re-striking properties. The electrode operates on AC as well as DC power source.

Applications : For all kind of mild steel structures like ship hulls, tanks & vessels, bridges, railway wagons, steel frames & grills, truck bodies etc.

Mechanical Properties

Mechanical Tests	Required Values
Yield Strength	330 N/mm ² (Min.)
Tensile Strength	410 - 540 N/mm ²
Elongation	22 % (Min.)
Impact (CVN) at 0°C	47 J (Min.)

* If Moist: Re-dry at 120°C For 1 Hr.

Weld Metal Chemistry (%)

Elements	C	Mn	Si	P	S
Range	0.12 Max	0.30-0.60	0.40 Max	0.040 Max	0.040 Max

Packing Specifications & Current Condition

Size (mm)	Pkts. / Case	Pcs. / Pkt	Current (Amp.) AC (50V) DC (±)
2.50 x 350	12	135	60 - 90
3.15 x 350	12 or 08	90	100 - 140
	04	175	
3.15 x 450	04	150/175	100 - 140
	08	90	
	04	5 Kg.	
4.00 x 450	08	60	140 - 200
	04	105	
	04	5 Kg.	
5.00 x 450	08	45	180 - 250
	04	65	
	04	5 Kg.	

“Noble – Characterized by all Excellent Qualities”