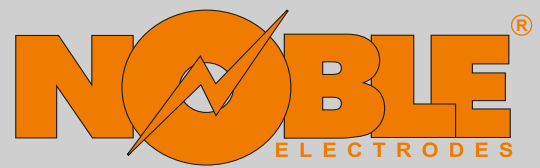


NOBLE - S

Mild Steel Radiographic Quality Electrodes



CLASSIFICATION

AWS - A5.1: E6013

Characteristics: NOBLE - S is a medium heavy coated electrode for radiographic quality welds. It produces uniform and finely rippled welds of superior finish. The special features of this electrode are smooth and steady arc, negligible spatters and self-detaching slag. The electrode operates on AC as well as DC power.

Applications: NOBLE - S is suitable for the welding of medium & high tensile steels such as boilers, pressure vessels, storage tanks, wagon building, construction equipment, pipe lines, furnace shells, bridges, auto components, ship hulls, cranes, girders 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	0.75 Max	0.35 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	04	225	60 - 90
3.15 x 350	04	140	90 - 130
3.15 x 450	04	140	90 - 130
4.00 x 450	04	85	130 - 190
5.00 x 450	04	60	170 - 240

“Noble – Characterized by all Excellent Qualities”