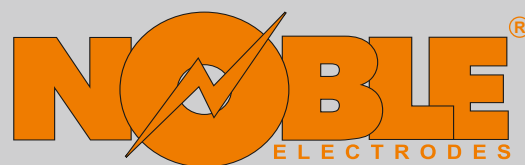


# NOBLE - SS

Mild Steel Radiographic Quality Electrodes



## CLASSIFICATION

IS - 814: ER4222X

AWS - A5.1: E6013

**Characteristics :** **NOBLE - SS** is a heavy coated all positional except vertical downward 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 - SS** is suitable for the welding of medium & high tensile steels such as boilers, pressure vessels, storage tanks, wagon building, pipe lines, furnace shells, bridges, auto components, ship hulls, cranes, girders etc. It is also suitable for thin sheet metals due to its fine droplet transfer.

## Mechanical Properties

Mechanical Tests	Required Values
Yield Strength	330 N/mm <sup>2</sup> (Min.)
Tensile Strength	410 - 540 N/mm <sup>2</sup>
Elongation	25 % (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	0.60 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 300 /350	08	2.500 kg.	60 - 90
2.50 x 350	04	200	60 - 90
2.50 x 350	05	4 kg.	60 - 90
3.15 x 350	04	125	90 - 130
3.15 x 350	08	2.500 kg.	90 - 130
3.20 x 350	05	4 kg.	90 - 130
3.15 x 450	04	125	90 - 130
4.00 x 350	05	4 kg.	130 - 190
4.00 x 450/350	04	70	130 - 190
5.00 x 450	04	55	170 - 240

*"Noble – Characterized by all Excellent Qualities"*