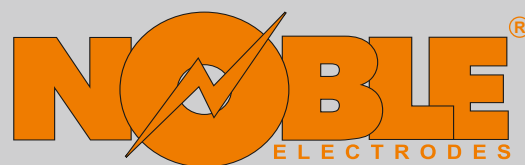


NOBLE - X

Mild Steel Radiographic Quality Electrodes



CLASSIFICATION

IS - 814: ER4212X

AWS - A5.1: E6013

Characteristics : **NOBLE - X** is a medium 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 - X** is suitable for the welding of medium & high tensile steels such as cross country pipe-line, pressure vessels, storage tanks, wagon building, construction equipment, 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	0.70 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 (-)
3.15 x 350/450	04	150	90 - 130
4.00 x 450	04	105	130 - 180

“Noble – Characterized by all Excellent Qualities”