

ORANGE GOLD



MILD STEEL GENERAL PURPOSE WELDING ELECTRODE (APPROVED BY: IRS – Grade 2, BIS, HPCL, VIZAG STEEL, CIDCO INDIA)

CLASSIFICATION: AWS/SFA 5.1: E 6013

DESCRIPTION: ORANGE GOLD is a general-purpose all positional, radiographic quality, medium coated rutile type electrode for mild steel, suitable for light & medium structural works.. The weld deposit is consistent in mechanical & radiographic quality. Slag is self-releasing and good restriking qualities. Can be used with both AC & DC Supply, gives least amount of spatter and smoke.

APPLICATIONS: It also finds suitability in areas such as Ship building, Wagon building, mild Steel vessels & tanks. Grills, Furnitures, Bridges, Coaches etc.

TYPICAL ALL WELD METAL CHEMISTRY (%):

C	Mn	Si	S	P
0.060 – 0.10	0.45 – 0.55	0.35 max	0.030 max	0.030 max

TYPICAL MECHANICAL PROPERTIES OF WELD METAL:

Ultimate Tensile strength N/mm ²	Yield strength N/mm ²	Elongation % L = 4d	Charpy V Notch Impact strength at 0°C Joules
460 - 520	380 - 440	25 - 30	65 - 80

CURRENT CONDITION: AC / DC (±)

RECOMMENDED CURRENT FOR EACH SIZE:

Size in MM	Current in AMPS
2.5 x 350	60 – 85
3.15 x 350	90 - 130
4.0 x 450	140 – 180
5.0 x 450	180 – 245

INSTRUCTIONS: Use recommended current range. Excess current results in increased spatter, undercuts and uneven slag covering. Exposed to humidity caused excessive moisture pickup. During welding this may cause some porosity hence, redry at 110 °C Temps for 1 hr.



ORANGE ELECTRODES INDUSTRIES
An ISO 9001:2015, 18001:2007 Certified Company