

BCM BahubaliTM

A medium-coated, general-purpose, rutile-based mild steel electrode for manual metal arc welding

Classification

AWS-E6013 IS 814 : 2004 Class - ER4211X

A general-purpose mild steel electrode with a rutile coating, the BCM Bahubali runs on low OCV in any position. Excellent running characteristics, minimum spatter, quick slag detachability, and medium penetration are all features of the BCM Bahubali. The radiography-quality weld deposit has good mechanical qualities.

TYPICAL ALL - WELD METAL PROPERTIES

Chemical Composition (%)	Mechanical Properties
C-0.10 Max, Mn- 0.35-0.55, Si - 0.30 Max S- 0.03 Max, P-0.03 Max	UTS- 410-540 N/mm ² Min, YS- 330 N/mm ² Min, Elongation (L=5d) - 22%Min, Impact (CVN) at 0°C-47(J Min

TYPICAL APPLICATIONS

Applications including sheet metal fabrication, chimneys, construction engineering jobs, truck and bus bodies, steel storage tanks, steel structures and frames are among those where BCM Bahubali is advised.

CURRENT RANGE & PACKING DATA

Size(mm)	Length(mm)	Current (amps)	No. of Electrodes is a carton	No. of Electrodes in a packet
4.50	440	160 - 200	480	40
3.50	440	120 - 150	720	60
2.80	440	70 - 100	1080	90
2.80	340	70 - 100	1080	90
2.35	340	50 - 70	1140	95

PACKING: Electrodes are packed in packets and twelve of these packets are shrink wrapped in a carton box.