

BCM Sigma

A medium-coated, general-purpose, rutile-based mild steel electrode for manual metal arc welding	Classification AWS-E6013 IS 814 : 2004 Class - ER4211X
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A general-purpose mild steel electrode with a rutile coating, the BCM Sigma runs on low OCV in any position. Excellent running characteristics, minimum spatter, quick slag detachability, and medium penetration are all features of the BCM Sigma. 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 Sigma 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	170 - 210	480 (12 pkts)	40
3.70	440	130 - 160	720 (12 pkts)	60
2.90	440	80 - 110	1080 (12 pkts)	90
2.90	340	80 - 110	1080 (12 pkts)	90
2.35	340	60 - 80	1600 (16 pkts)	100

PACKING: Electrodes are packed in packets which are shrink wrapped in a carton box.