TECHNICAL DATA SHEET

BESTARC
STRONGEST WELDING ELECTRODES

BESTARC MS-11 AWS: A 5.1 E6013

BESTARC MS-11 rutile type mild steel general purpose AC/DC electrode developed especially for easy and efficient welding in all positions. The electrode deposits excellent weld bead with smooth and stable arc characteristics, minimized spatter, easily detachable thin slag, easy striking and restriking characteristics. The weld deposit assures very good chemical and mechanical properties.

TYPICAL APPLICATIONS

- Mild steel structures
- Wagons
- Auto bodies
- Storage tanks
- Ship building
- Sheet metal fabrications

CLASSIFICATION/CODING

- IS 814: ER4211
- AWS: A 5.1 E6013
- ASME SFA 5.1: E6013

WELDING PROCESS AND POSITIONS

- SMAW (MMAW)
- All Positions

AVAILABLE SIZES

- 2.50 X 350 mm
- 3.15 X 350 mm
- 3.15 X 450 mm
- 4.00 X 450 mm
- 5.00 X 450 mm

WELD METAL CHEMISTRY

%C	%Mn	%Si
0.040-0.120%	0.400-0.620%	0.150-0.400%

RECOMMENDED CURRENT RANGE

Polarity	2.50 mm	3.15 mm	4.00 mm	5.00 mm
AC	60-90	100-140	140-180	180-230
DC±	60-90	100-140	140-180	180-230

ALL WELD MECHANICAL PROPERTIES OF WELD METAL

Properties	Y.S. (MPa)	U.T.S. (MPa)	ELN % (L= 4d)	CVN IMP (J at 0°c)
Requirements	330 (min.)	410 - 540	22 (min.)	47 (min.)
Typical Results (as welded)	370 (min.)	450 - 530	22 (min.)	50 (min.)

Note
Test results for mechanical properties and weld metal chemistry were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

Information given in this data sheet is accurate to the best of our knowledge at the time of printing. It is subject to change.

VNC Rising with values
VNC Electrodes
3, Industrial Estate, S. Vellalapatti, Karur 639004 TN, India.
✆ 1800 599 3939 www.vncgroup.com