

716-0045 to 716-0070

Zodian Universal



BS 639:1986
AWS A5FA 5.1-91

E4322 R[11]
E6013

Description and applications

A versatile rutile-cellulosic electrode for welding in all positions, including vertical down. Very easy to use even in difficult situations such as bridging gaps, corners etc., the electrode has a consistently smooth and crisp arc which is tolerant to a wide range of welding parameters such as current setting, arc length and travel speed. Zodian Universal is the ideal electrode for mild steel fabrication work either in the shop or on site.

Equivalent consumables include Saffire Super Steel (TIG), Bostrand LW1 (MAG), Coromig 58 (cored wire) and Bostrand S1 with Satinarc BX100 (submerged arc).

Approvals

ABS 2	DNV 2	MOD . MS to 25mm
BV 2	LRS 2	(Navy) B & BX to 12mm

All-weld metal properties

Composition wt%	Mechanical	As-welded
C 0.10 max	YS	380 min N/mm ²
Si 0.20-0.40	UTS	460-550 N/mm ²
Mn 0.30-0.60	Elongation	24 min %
S 0.030 max	CVN at -10°C	61 min ave J
P 0.030 max		

Current range AC (min OCV 50) or DC +/-

Size	mm	2.5	3.2	4.0	5.0	6.0
Current	amps	70-95	90-120	130-190	180-230	220-300

Packaging

Item No.	Size mm	Length mm	Approx. wt 1000 pcs,kg	Contents per carton	
				Pieces	Approx. wt kg
4754253310	2.5	350	18	804	14.4
4754323310	3.2	350	29	498	14.4
4754403300	4.0	350	43	405	17.4
4754504300	5.0	450	87	255	22.2
4754604300	6.0	450	125	180	22.5