

ESAB VORDIAN

ESAB VORDIAN is an all position medium heavy rutile coated mild steel welding electrode of outstanding quality permitting the use of low open circuit voltages. ESAB VORDIAN is extremely suitable for flat and horizontal-vertical positions, as well as for vertical and overhead welding.

Specifications	
Classifications	SFA/AWS A5.1 : E6013 IS 814 : ERR4221X
Approvals	BV : 2 IRS : 2 LR : 2m

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	AC, DC+-
Alloy Type	C-Mn
Coating Type	Rutile

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	430 MPa	490 MPa	29 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
AWS		
As Welded	0 °C	90 J

Typical Weld Metal Analysis %		
C	Mn	Si
0.07	0.35	0.20

Deposition Data	
Diameter	Current
2.5 x 350.0 mm	50-80 A
3.15 x 450.0 mm	70-120 A
4.0 x 450.0 mm	100-170 A
5.0 x 450.0 mm	150-240 A