

# CHE421

## Covered Welding Rod for Mild Steels

AWS A5.1 E6013

BS EN ISO 2560-B-E 43 13 A

GB/T 5117 E4313

**Type of Covering:** High titania, potassium

**Welding Position:** F, H, HF, OH, V

**Type of Current:** AC, DCEP or DCEN

### Features & Applications

CHE421 is a mild steel welding rod and it is suitable for intermittent welding to sheet steels and small work pieces as well as cosmetic welding with smooth and shiny appearance.

### Chemical Composition of Deposited Metal (%)

	C	Mn	Si	S	P	Ni	Cr	Mo	V
Standard	≤0.20	≤1.20	≤1.00	—	—	≤0.30	≤0.20	≤0.30	≤0.08
Typical	0.070	0.40	0.25	0.020	0.025	0.017	0.025	0.002	0.01

### Mechanical Properties of Deposited Metal (AW)

	Tensile Strength R <sub>m</sub> (MPa)	Yield Strength R <sub>eL</sub> (MPa)	Elongation A <sub>4</sub> (%)
Standard	≥430	≥330	≥17
Typical	480	380	29

**X-ray radiographic inspection:** Grade II

### Sizes & Recommended Current (AC or DC)

Size (mm)	2.0x300	2.5x300	3.2x350	4.0x400	5.0x400	
Current (A)	F, H	40-70	60-90	80-130	150-190	220-280
	V, OH	35-60	55-80	70-120	120-160	—

**Notice:** Normally the rod does not need to re-bake in case it is affected with damp seriously re-bake it at 150°C for 30-60minutes before use.