

GENERAL PURPOSE MILD STEEL ELECTRODE

The ideal, general purpose electrode. ISOARC 112 is a heavy-coated rutile electrode that gives a quality finish. The arc is easy to control and produces minimal spatter. Low amperage performance prevents distortion. Contact welding enables thin sections to be welded easily. Any slag is easily removed

Features & Benefits	Typical Applications
▪ Excellent strikeability and restrikeability ▪ Smooth, stable arc ▪ Low spatter ▪ Easy slag removal ▪ Excellent bead appearance ▪ Low hydrogen weld deposit ▪ Suitable for AC and DCEP ▪ All-position welding (except vertical down)	▪ Structural steel fabrication ▪ General engineering ▪ Pressure vessels ▪ Mining and quarry equipment ▪ Construction ▪ Maintenance & repair ▪ Agricultural equipment ▪ Heavy fabrication

Technical Information

Classification	AWS A5.1 E6013
Polarity	AC / DCEP
Welding Positions	Flat ▪ Horizontal ▪ Vertical Up ▪ Overhead
Base Materials	Carbon steels and low alloy steels
Storage	Store dry area above the ground

Mechanical Properties	Typical
Tensile Strength	≥ 490 MPa
Yield Strength	≥ 400 MPa
Elongation	≥ 22%

Current Range	
2.5mm	70 - 100A
3.2mm	90 - 140A
4.0mm	120 - 180A
5.0mm	170 - 240A



Manufactured by Thuthuka Welding Products (Pty) Ltd

Manufactured under an ISO 9001 quality management system using internationally proven formulations to deliver consistent welding performance and dependable quality.