



**GALO**  
WELDING ELECTRODES



IS 814 : 2004



CML No. 6900101214

**“COCK” -  
FLAT STITCHING WIRE**



**Process**

Electro Plating Process

**Size of the Wires**

- 2.60 mm width X 0.55 mm Thickness
- 2.30 mm width X 0.55 mm Thickness
- 1.40 mm width X 0.55 mm Thickness

**Packing**

- 2.00 Kgs in a coil
- 12 coils X 2.00kg = 24 kgs in carton box

**“COCK” - Round Stitching Wire**

- Stitching wire made from the best mild steel galvanized iron and processed to suit every stitching.
- The coils/spools are in straight length without joints & gauge variations which avoids wastage.
- The wire is rust resistant with no deviation & weather does not affect its quality.
- The Coils are shrink packed and wrapped in a high quality Kraft paper, to withstand adverse weather conditions.
- Good corrosion resistance due to eco-friendly coating. High penetrating power due to restricted production tolerances.
- At every stage processing it is supervised by competent technical personnel to ensure utility.

**TECHNICAL SPECIFICATIONS**

SWG (gauge)	Size (mm.)	Tolerance (mm.)	Meter/ (kgs)	Feet (kgs)
20	-	-	-	-
22	0.71	± 0.02	320	1055
24	0.56	± 0.02	520	1700
25	-	-	-	-
26	0.45	± 0.02	760	2495

**SPOOL DIMENSION**

Capacity (kgs)	Flange (mm)	Barell (mm)	Traverse (mm)	Overall (mm)	Bore (mm)
2	133	53	44	50.0	19.5
3	138	53	48	57.0	18.5
4	154	67	56	63.0	19.5
5	171	72	53	61.5	68.0
10	225	72	53	61.5	68.0
15	300	205	103	89.8	51.5
40	355	224	160	200.0	36.0



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**SRI KALISWARI STEEL PRIVATE LIMITED**

**Company Profile**

We, Sri Kaliswari Steel Private Limited, Sivakasi are proud to introduce ourselves as one of the manufacturers of Welding Consumables in India. Our Industry is part of Sri Kaliswari Group of Companies founded by Sri. A.Shunmuga Nadar in the year 1923. This is a Private Limited concern. We are manufacturing Galo Welding & RG Welding Brand of Welding Electrodes. The quality of our welding consumables are far superior, cause our production is carried out under the control of highly experienced technicians. We hope & believe strongly that you will give us an opportunity to meet your demands through our products.

**Sri Kaliswari Group of Companies:**

- Sri Kaliswari Fireworks Private Limited
- Sri Kaliswari Colour Match Works
- Sri Kaliswari Colour Match Works(Packaging Division)
- Sri Kaliswari Metal Powders Private Limited
- Sri Kaliswari Roadways Private Limited
- Sri Kaliswari Fireworks Private Limited ( Printing Department )
- Sri Kaliswari College, Sivakasi
- Sri Kaliswari Institute of Management and Technology.
- Sri Kaliswari Le Orchids
- Sri Kaliswari Packaging Private Limited
- Sri Kaliswari Feeds Private Limited
- Sri Kaliswari Fireworks Pvt.Ltd.( COCK Wood Press Oil )

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Since 1923



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STEEL PRIVATE LIMITED**

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**GALO WELDING - 6013**



**RUTILE TYPE GENERAL PURPOSE ALL POSITION WELDING ELECTRODE**



**CLASSIFICATION** : AWS/SFA-5.1: E 6013,  
IS: 814 4211X

**APPROVAL** : BIS

**CHARACTERISTICS** :

- 1) Easy striking and Restriking of the arc.
- 2) Very stable and smooth arc.
- 3) Self lifting slag.
- 4) Very low spatter.
- 5) Medium penetration.
- 6) Fine Ripples and shiny beads.
- 7) Suitable for all position welding.
- 8) Suitable for X-ray quality welds.

**APPLICATION** : Ideally suited for welding of pipelines and boiler tubes. A very wide range of jobs can be tackled effectively with this electrode.

Typical applications are

- |                            |                 |                        |
|----------------------------|-----------------|------------------------|
| 1. Tanks                   | 5. Ships        | 9. Sheet metal work    |
| 2. Trawlers                | 6. Dredgers     | 10. Structural Welding |
| 3. Machinery constructions | 7. Rail coaches |                        |
| 4. Bridges                 | 8. Wagons       |                        |

**ALL WELD CHEMICAL COMPOSITION %**

C	Mn	Si	S	P
0.08 max	0.4-0.6	0.25 max	0.03 max	0.03 max

**ALL WELD MECHANICAL PROPERTIES:**

YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	EL% (1=4d)	CHARPY "V" NOTCH IMPACT AT 0°C : 50 - 60 J
420 - 440	450 - 470	22 - 25 %	

**DIEMENSION, CURRENT CONDITION & PACKING DATA: E 6013**

Size		Current conditions (Amps)	Packing			
Diameter mm	length		packing	No. of pcs/Pkt	No. of Pkt/case	No. of Case/ton
2.50	350	80 - 100	2.5 kgs	135	8	50
3.15	350	90 - 120	2.5 kgs	90	8	50
3.15	450	90 - 120	3.5 kgs	90	8	35
4.00	450	140 - 160	3.5 kgs	60	8	35
5.00	450	170 - 210	4.5 kgs	50	8	33



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**GALO WELDING - 7018**



**BASIC COATED LOW HYDROGEN IRON POWDER ELECTRODE**



**CLASSIFICATION** : AWS/SFA-5.1: E 7018,  
IS: 814 5426 H3JX

**APPROVAL** : BIS

**CHARACTERISTICS** :

- 1) Suitable for all position welding.
- 2) Easy slag removal.
- 3) Fine ripples with smooth bead.
- 4) Stable arc with low spatter.
- 5) Excellent radiographic quality.
- 6) High tensile strength and CVN impact properties at sub zero temperatures.
- 7) High resistance to hydrogen induced cracking.

**APPLICATION** : Basic coated low hydrogen iron powder electrode for all position Radiographic welds. The tough strong crack free weld is suitable for conditions involving heavy stresses and dynamic loads.

Typical applications are

- 1) Include boilers and pressure vessels
- 2) Bridges, Pumps and compressors
- 3) High thickness pipes and rail wagons & coaches.

**ALL WELD CHEMICAL COMPOSITION %**

C	Mn	Si	S	P
0.10 max	1.3 - 1.6	0.40 max	0.03 max	0.03 max

**ALL WELD MECHANICAL PROPERTIES:**

YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	EL% (1=4d)	CHARPY "V" NOTCH IMPACT AT -29°C : 80-100 J
460 - 480	550 - 570	25 - 27 %	

**DIEMENSION, CURRENT CONDITION & PACKING DATA: E 7018**

Size		Current conditions (Amps)	Packing			
Diameter mm	length		packing	No. of pcs/Pkt	No. of Pkt/case	No. of Case/ton
2.50	350	80 - 100	4 kgs	186	4	62
3.15	350	110 - 130	4 kgs	92	4	62
4.00	450	160 - 180	3.5 kgs	49	5	50
5.00	450	200 - 240	4 kgs	39	5	50



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**GALO WELDING - CO2/MIG WELDING**



**COPPER COATED SOLID WELDING WIRE FOR CO2/MIG WELDING**



Classifications	Weld Chemistry %	Weld Metal Mechanical Properties
Classification AWS A 5.18 : ER 70 S-6 IS : S4 - C 504	C 0.07 - 0.15	YS 470N/mm <sup>2</sup>
	Mn 1.40 - 1.85	UTS 590 N/mm <sup>2</sup>
	Si 0.80 - 1.15	Elongation 25%
	S 0.035 Max	Impact Value (CVN)
	P 0.025 Max	27°C - 150 J
Cu 0.50 Max	-30°C - 45 J	

**CHARACTERISTICS AND APPLICATIONS:**

- Stable arc & smooth flow in all range of currents and in all positions of welding
- All position welding with minimum spatter under optimum welding conditions.
- Uniform Copper Coating for excellent electrical contact and for corrosion resistance ensures friction free feeding in torches
- Produces excellent radiographic welds in M.S., Low Carbon Steel of strength up to 55kg/mm<sup>2</sup>
- Suitable for CO<sub>2</sub> & Argon/CO<sub>2</sub> & Mix Shielding gases.
- Available in layer winding for 0.80mm, 1.00 mm, 1.20mm & 1.60mm wires

Size of the Wires :

0.80 mm, 1.00 mm, 1.20 mm, 1.60 mm

Specifications :

**Domestic** : Supplied in DIN 280 & DIN 300 as Spool  
Weight 12.50 kg / 15 kg wire in a spool  
Spool Packed in a shrink pack with vacuum pack  
Spool packed in carton box

**Export** : 80 carton box in a pallet (80 Box x 12.5 Kgs = 1000 Kgs)  
Container Loadability = 23 tonnes