ESAB CSA

Cost effective means to crack resistant welding

The most crack-resistant electrode for welding steels of limited weldability, Esab CSA gives a tough weld metal that is designed to give superior crack resistance than what is available with normal 18-8-6 varieties. The electrode has high current tolerance and maximum deposition rate.

Extremely suitable for crack free root-runs in 14% Mn steels.

ALLOY BASE: Fe, Cr, Ni, Mn

SPECIAL FEATURES

- Deposition efficiency: 190% (approx.)
- Electrode gives high current tolerance and maximum deposition rate.
- Most economic electrode for dissimilar steel joints.

APPLICATIONS

Welding and repairing manganese steels, cladding worn out parts in bulldozers, rail crossing, dredgers, contact layer etc. Joining austenitic manganese steel to carbon steel or hardenable steels without preheat and welding machine parts to excavating machine components.

PROPERTIES

UTS		: 57-62 kg/mm^2
Hardness	: As deposited	: 20-22 HRC
	Work hardened	: 45-49 HRC

(Contd...)

WELDING PROCEDURE

- 14% Mn steel should never be preheated for welding.
- Heat input to the base metal should be kept minimum.
- The weld bead may be peened with ball pen hammer just after welding.
- Quenching has no adverse effect on welding and should be adopted whenever possible after slag removal and peening.
- If required the Mn steel job may be submerged in water during welding.

CURRENT RANGE : (AC 70, DC±)

Size (mm)	Length (mm)	Current Range (Amp)
3.15	350	100-150
4.00	350	150-200
5.00	350	200-250