

ESAB FERROARC

A rutile coated general-purpose electrode for SMAW

Classification AWS A5.1: E6013
IS 814: ER4211X

DESCRIPTION

ESAB FERROARC is a medium coated general purpose mild steel electrode, which operates on low OCV (50V) AC in all positions. ESAB FERROARC delivers smooth and stable welding arc with low spatter, excellent slag detachability and smooth weld bead appearance. The weld deposit is of radiographic quality.

APPROVALS: ABS, BV, DNV, IBR, IRS, LRS, MMD, MN Dastur & TOYO

WELDING CURRENT: DC_±, AC 50V

TYPICAL PROPERTIES

Weld Metal Composition (Wt.%)		All Weld Mechanical Properties	
C	0.08	YS (N/mm ²)	430
Si	0.20	UTS (N/mm ²)	500
Mn	0.35	Elongation (%)	26
		Impact (CVN) @ 0°C (Joules)	80

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	50-80	300	900
3.15	350	60-120	190	570
3.15	450	60-110	185	555
4.00	450	90-170	125	375
5.00	450	130-280	85	255

PACKING: Electrodes are packed in cartons and three of these cartons are shrink wrapped in a cardboard box.