



ESAB FERROSPEED PLUS

A rutile coated all-round electrode for SMAW

Classification AWS A5.1: E6013
IS 814: ER4211X

DESCRIPTION

ESAB FERROSPEED PLUS is a medium-heavy coated mild steel welding electrode for all positions, having good mechanical properties and arc characteristics. ESAB FERROSPEED PLUS operates on low open circuit voltage and its good running characteristics results in excellent weld finish of radiographic quality. ESAB FERROSPEED PLUS is also known for its superior V-down welding capabilities.

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

WELDING CURRENT: DC \pm , AC 50V

TYPICAL PROPERTIES

Weld Metal Composition (Wt.%)		All Weld Mechanical Properties	
C	0.08	YS (N/mm ²)	400
Si	0.18	UTS (N/mm ²)	500
Mn	0.30	Elongation (%)	27
		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
2.5	350	50-85	190/265	760/795
3.15	350	60-120	140/195	560/585
3.15	450	60-110	140/190	560/570
4.00	450	80-180	85/115	340/345
5.00	450	100-235	55/75	220/225

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