

# Carbon Steel Electrodes



## ESAB FERROSPEED

A rutile coated general-purpose electrode for SMAW

Classification AWS A5.1: E6012  
IS 814: ER4124

### DESCRIPTION

ESAB FERROSPEED is a rutile-coated general-purpose electrode for welding structures that are not subjected to heavy dynamic loading and is specially designed for higher tolerance to less cleaned plates and poor joint fit-ups. The electrode has high current carrying capacity and produces quality weld metal.

**APPROVALS:** ABS, BV, DNV, IBR, IRS, LRS & MMD

**WELDING CURRENT:** DC<sub>±</sub>, AC 70V

### TYPICAL PROPERTIES

Weld Metal Composition (Wt.%)		All Weld Mechanical Properties	
C	0.08	YS (N/mm <sup>2</sup> )	430
Si	0.20	UTS (N/mm <sup>2</sup> )	520
Mn	0.35	Elongation (%)	25
		Impact (CVN) @ +20°C (Joules)	70

### CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
3.15	450	95-150	150	600
4.00	450	140-190	100	400
5.00	450	180-260	65	260

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