



ESAB FERROWELD 1

A basic coated low hydrogen electrode for SMAW

Classification AWS A5.1: E7016
IS 814: EB5424H₃X

DESCRIPTION

ESAB FERROWELD 1 is a basic coated, hydrogen controlled electrode for welding mild, medium tensile, low alloy, free cutting and difficult to weld steels and grey cast iron (non-machinable deposits) in all positions, using AC or DC. The composition of coating ensures complete absence of porosity and cracking.

WELDING CURRENT : DC_±, AC 70V

TYPICAL PROPERTIES

Weld Metal Composition (Wt.%)		All Weld Mechanical Properties	
C	0.06	YS (N/mm ²)	450
Si	0.70	UTS (N/mm ²)	540
Mn	1.00	Elongation (%)	32
		Impact (CVN) @ -30°C (Joules)	60

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	75-105	170	680
3.15	450	95-150	100	400
4.00	450	140-190	65	260
5.00	450	190-260	45	180

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