

ESAB 130



A low hydrogen, low alloy electrode for welding low alloy, high strength structural steels



Classification AWS A5.5: E 13018-G
 BS 611 HJ
 IS E838 BG 129Fe
 DIN E Kb

DESCRIPTION

ESAB 130 is an all position low hydrogen electrode designed to deposit high strength as well as highly ductile and tough weldmetal for welding of fully killed high strength steels. The electrode deposits finely rippled weldbead which is of radiographic quality. The weldmetal is also low in diffusible hydrogen.

TYPICAL APPLICATIONS

Recommended for welding very high strength steels like XABO-90, penstocks, earthmoving equipment, casting repair, etc.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.08	S	0.025	YS	880 N/mm ²
Mn	1.70	Ni	2.80	UTS	970 N/mm ²
Si	0.45	Cr	0.90	EL (L=5d)	18%
Mo	0.50			Impact (CVN) at 27°C	90J
V	0.05			0°C	60J
P	0.025				

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
3.15	450	90-125	90	360
4.00	450	120-180	60	240
5.00	450	160-240	40	160

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