

ESAB C 23 S



A rutile coated general-purpose electrode for MMAW (High Recovery)



Classification AWS A5.1: E 7024
IS: 814 ERR 5234KX

DESCRIPTION

ESAB C 23 S is a heavy coated rutile-iron powder electrode having a deposition efficiency of 130-140% and is specially designed for very fast welding of unalloyed steels in downhand and for standing fillets by contact welding. It is also widely used in filling of butt welds. ESAB C 23 S is less sensitive to plate impurity and has excellent weld appearance with a self-lifting slag at all speeds. Above all, weld deposit is of radiographic quality.

APPROVALS

BV Gr.3.3YH, IRS Gr.3H 3YH

WELDING CURRENT: DC \pm , AC 50V

TYPICAL APPLICATIONS

Welding of thick plates in shipbuilding, penstock fabrication, air-receivers, compressors, boilers, structural works, heavy beams and girders etc. This electrode is ideal where the final bead appearance coupled with Radiographic and mechanical properties are required.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.09	Mn	0.98	YS	475 N/mm ²
Si	0.67	S	0.018	UTS	550 N/mm ²
P	0.025			EL (L=5d)	26%
				Impact (CVN) at 0°C	90J

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
3.15	350	120-150	75	300
4.00	485	180-210	55	220
5.00	450	260-340	30	120
6.30	450	320-430	15	60

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