

ESAB FERROARC



A rutile coated general-purpose electrode for MMAW

Classification AWS A5.1: E 6013
IS: 814 ER 4211X



DESCRIPTION

ESAB FERROARC is a medium coated general-purpose mild steel electrode, that operates on low OCV (50 V) AC in all positions and is ideally suited for general structural welding, welding of pipe sockets, grill, general repair welding in automobile garages etc. ESAB FERROARC delivers smooth and stable welding arc with low spatter and smoke, excellent slag detachability and smooth weld bead appearance. The weld deposit is of radiographic quality.

APPROVALS

ABS Gr.2, BIS BV Gr.2, DNV Gr.2, IRS Gr.2, LRS Gr.2, MMD, MN Dastur, RDSO C2, CIB

WELDING CURRENT: DC \pm , AC 50V

TYPICAL APPLICATIONS

Ideally suited for general structural welding, welding of pipe sockets, general welding fabrication, etc.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.08	Mn	0.40	YS	410 N/mm ²
Si	0.25	S	0.02	UTS	490 N/mm ²
P	0.02			EL (L=5d)	26%
				Impact (CVN) at + 0°C	60J

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	40-100	140	840
3.15	350	95-125	90	540
4.00	450	125-175	60	360
5.00	450	165-260	35	210
6.30	450	195-290	25	150

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