

# ESAB FERROSPEED



## A rutile coated general-purpose electrode for MMAW

Classification      AWS A5.1: E 6012  
IS: 814 ER 4124



### DESCRIPTION

ESAB FERROSPEED is one of the most popular and well-known welding electrodes in India for decades. ESAB FERROSPEED is a rutile-coated electrode for welding general-purpose structures that are not subjected to heavy dynamic loading. ESAB FERROSPEED is specially designed for higher tolerance to less cleaned plates and poor joint fit-ups. Unique balance of arc force and slag fluidity makes the electrode easily manoeuvrable in all positions and because of its versatility and economy has found wide acceptance for welding mild steel. The weld provides good penetration and an easily detachable slag.

### APPROVALS

ABS Gr.1, BIS, BV Gr.1, CIB, DNV Gr.1, IRS Gr.1, LRS Gr.1, MMD.

**WELDING CURRENT** : DC±, AC 70V

### TYPICAL APPLICATIONS

Chimney, machine building, repair-jobs, shaft reclamation, ship building, storage tanks, bus and truck bodies, cement mills, rolling mills, barge-building, etc.

### TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.09	S	0.02	YS	420 N/mm <sup>2</sup>
Si	0.20	Mn	0.40	UTS	490 N/mm <sup>2</sup>
P	0.02			EL (L=5d)	23%
				Impact (CVN) at + 27°C	70J

### CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
3.15	450	95-125	150	600
4.00	450	125-175	100	400
5.00	450	165-250	65	260
6.30	450	195-350	45	180

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