

# ESAB RSQ



## A specially designed stainless steel electrode for welding dissimilar and difficult to weld steel



### DESCRIPTION

ESAB RSQ is a specially designed basic coated stainless electrode for welding dissimilar and difficult to weld steels. The weld deposit work hardens and provides good impact resistance and has excellent thermal shock resistance. ESAB RSQ welds with a smooth arc with very little spatter and has a slag system that provides good wetting with a slag cover that is easily detachable depositing a weldbead that is smooth, shiny and uniform.

**APPROVAL:** CQA (Met)

**WELDING CURRENT:** DC +

### TYPICAL APPLICATIONS

ESAB RSQ is especially recommended for use as buffer layer for reconditioning worn out Mn steel rail crossing. The weldbead provides excellent metal to metal frictional wear resistance.

### TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.03	Ni	12.00	UTS	640 N/mm <sup>2</sup>
Mo	3.30	Si	0.70	EL (L=4d)	36%
Cr	22.00	Mn	1.2	Hardness	
S	0.015	P	0.018	As welded	150-200 VHN
				Work-hardened	400-430 VHN

### CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	50-80	—	—
3.15	350	60-100	65	325
4.00	350	90-145	40	200
5.00	350	130-180	30	150

**PACKING:** Electrodes are packed in heat sealed plastic cartons and five of these cartons are shrink wrapped in a cardboard box.