ESAB FERROARC



ESAB FERROARC is a medium coated general purpose mild steel electrode, which operates on low OCV (50V) AC in all positions. It delivers smooth and stable welding arc with low spatter, excellent slag detachability and smooth weld bead appearance. The weld deposit is of radiographic quality.

Classifications:	SFA/AWS A5.1:E6013, IS 814:ER4211X
Approvals:	ABS 2, BV 2, DNV 2, IBR E6013, IRS 2, LR 2m

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current:	AC, DC+-
Alloy Type:	C-Mn
Coating Type:	Rutile

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	420 MPa	500 MPa	26 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As Welded	0 °C	80 J

Typical Weld Metal Analysis %

C	Mn	Si
0.08	0.35	0.20

Current Range

Diameter	Current
2.5 x 350 mm	50-80 A
3.15 x 350 mm	70-120 A
3.15 x 450 mm	70-120 A
4.0 x 450 mm	90-170 A
5.0 x 450 mm	150-260 A