# ESAB FERROSPEED PLUS




ESAB FERROSPEED PLUS is a medium-heavy coated mild steel welding electrode for all positions, having good mechanical properties and arc characteristics. It operates on low open circuit voltage and its good running characteristics results in excellent weld finish of radiographic quality. It is also known for its superior V-down welding capabilities.

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|---|---|
| **Classifications:** | SFA/AWS A5.1:E6013, IS 814:ER4211X |
| **Approvals:** | ABS 2, BV 2, DNV 2, IBR E6013, IRS 2, LR 2m, PDIL E6013, M N Dastur E6013 |

*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 | 400 MPa | 500 MPa | 27 % |

## 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 | 0.30 | 0.20 |

## Current Range

| Diameter | Current |
|---|---|
| 2.5 x 350 mm | 50-85 A |
| 3.15 x 350 mm | 70-120 A |
| 3.15 x 450 mm | 70-110 A |
| 4.0 x 450 mm | 90-180 A |
| 5.0 x 450 mm | 150-250 A |