

## ESAB RSW

ESAB RSW is a rutile coated all positional electrode for welding of complex dissimilar alloys and high strength steels with low heat input, giving sound joints free from any cracks and fissures. It is a specially designed high alloy electrode for joining steels of unknown composition. The weld metal has high strength combined with excellent resistance against impact, heat (excellent scaling resistance up to 1150°C) and corrosion.

Specifications	
Classifications	SFA/AWS A5.4 : E312-15

Welding Current	DC+
Ferrite Content	30-45 FN
Alloy Type	Stainless Duplex
Coating Type	Basic

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	662 MPa	818 MPa	23 %

Typical Weld Metal Analysis %									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.11	2.06	0.008	0.008	0.023	10.44	28.60	0.04	0.06	0.094

Typical Weld Metal Analysis %	
Nb	
0.03	

Deposition Data	
Diameter	Current
2.5 x 350.0 mm	60-100 A
3.15 x 350.0 mm	80-120 A
4.0 x 350.0 mm	120-170 A
5.0 x 350.0 mm	