

ESAB C23S

ESAB C23S is a heavy coated rutile-iron powder electrode having a metal recovery of 130-140%. It is specially designed for very fast welding of unalloyed steels in downhand position and for standing fillets by contact welding.

Specifications

Classifications	SFA/AWS A5.1 : E7024 IS 814 : ERR5234KX
Approvals	IRS : 2

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	460 MPa	550 MPa	23 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As Welded	0 °C	60 J

Typical Weld Metal Analysis %

C	Mn	Si
0.08	0.80	0.40

Deposition Data

Diameter	Current
3.15 x 450.0 mm	120-150 A
4.0 x 450.0 mm	140-200 A
5.0 x 450.0 mm	180-250 A