

## ESAB FERROSPEED

ESAB FERROSPEED is a rutile-coated general-purpose electrode for welding structures that are not subjected to heavy dynamic loading and is specially designed for higher tolerance to less cleaned plates and poor joint fit-ups. The electrode has high current carrying capacity and produces quality weld metal.

Specifications	
Classifications	SFA/AWS A5.1 : E6012 IS 814 : ER4124
Approvals	IRS : 1 LR : 1m

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	430 MPa	520 MPa	25 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
AWS		
As Welded	27 °C	85 J
As Welded	20 °C	70 J

Typical Weld Metal Analysis %		
C	Mn	Si
0.08	0.35	0.20

Deposition Data	
Diameter	Current
3.15 x 450 mm	95-140 A
4.0 x 450 mm	120-190 A
5.0 x 450 mm	170-260 A