

ESAB VORTIC

ESAB VORTIC is a medium coated general purpose mild steel electrode, especially designed for use in vertical and over head positions. This is a rutile coated electrode, with fast freezing slag and excellent slag detachability even in deep grooves.

Specifications

Classifications	SFA/AWS A5.1 : E6013 IS 814 : ER4224X
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	430 MPa	470 MPa	25 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As Welded	0 °C	70 J

Typical Weld Metal Analysis %

C	Mn	Si
0.07	0.40	0.20

Deposition Data

Diameter	Current
2.5 x 350.0 mm	50-100 A
3.15 x 450.0 mm	100-130 A
4.0 x 450.0 mm	130-180 A
5.0 x 450.0 mm	150-260 A