

ESAB Ferroarc

ESAB FERROARC is a medium coated general purpose mild steel electrode, which operates on low OCV (50V) AC in all positions. It delivers smooth and stable welding arc with low spatter, excellent slag detachability and smooth weld bead appearance. The weld deposit is of radiographic quality.

Specifications	
Classifications	SFA/AWS A5.1 : E6013 IS 814 : ER4211X
Approvals	ABS : 2 BV : 2 DNV : 2 IBR : E6013 IRS : 2 LR : 2m

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	420 MPa	500 MPa	26 %

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	0.35	0.20

Deposition Data	
Diameter	Current
3.15 x 350 mm	70-120 A
2.5 x 350 mm	50-80 A
3.15 x 450 mm	70-120 A
4.0 x 450 mm	90-170 A
5.0 x 450 mm	150-260 A