

# ESAB FERROWELD 1

ESAB FERROWELD 1 is a basic coated, hydrogen controlled electrode for welding mild, medium tensile, low alloy, free cutting and difficult to weld steels and grey cast iron (non-machinable deposits) in all positions, using AC or DC. The composition of coating ensures complete absence of porosity and cracking.

Specifications	
Classifications	SFA/AWS A5.1 : E7016 IS 814 : EB5424H3X
Approvals	IBR : E7016

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	AC, DC+-
Diffusible Hydrogen	<5.0 ml/100g
Alloy Type	C-Mn
Coating Type	Basic

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	450 MPa	540 MPa	32 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
AWS		
As Welded	-30 °C	60 J
As Welded	-20 °C	90 J

Typical Weld Metal Analysis %		
C	Mn	Si
0.06	1.00	0.70

Deposition Data	
Diameter	Current
2.5 x 350.0 mm	60-90 A
3.15 x 450.0 mm	95-140 A
4.0 x 450.0 mm	130-190 A
5.0 x 450.0 mm	180-240 A