

ESAB FERROWELD W2

ESAB FERROWELD W2 is a Cr-Ni-Cu alloyed basic coated hydrogen controlled electrode, suitable for welding of weathering steels, steels having greater resistance to atmospheric corrosion as compared to normal steels and high tensile strength steels. The electrode is designed to provide excellent striking and re-striking properties, stable arc, easily detachable slag and smooth weld bead. It is specially recommended for weathering steels like COR-TEN A/B and their equivalents.

Specifications

Classifications	SFA/AWS A5.5 : E8018-W2
Welding Current	DC+
Diffusible Hydrogen	< 5 ml/100g
Alloy Type	Cr-Ni-Cu alloyed
Coating Type	Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	560 MPa	650 MPa	27 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As Welded	-20 °C	80 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Cu
0.06	0.90	0.50	0.60	0.60	0.40

Deposition Data

Diameter	Current
2.5 x 350.0 mm	50-90 A
3.15 x 450.0 mm	75-140 A
4.0 x 450.0 mm	140-190 A
5.0 x 450.0 mm	190-240 A