

ESAB FERROSPEED PLUS

ESAB FERROSPEED PLUS is a medium-heavy coated mild steel welding electrode for all positions, having good mechanical properties and arc characteristics. ESAB FERROSPEED PLUS operates on low open circuit voltage and its good running characteristics results in excellent weld finish of radiographic quality. ESAB FERROSPEED PLUS is also known for its superior V-down welding capabilities.

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

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	400 MPa	500 MPa	27 %

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	0.30	0.20

Deposition Data	
Diameter	Current
2.5 x 350.0 mm	50-85 A
3.15 x 350.0 mm	70-120 A
3.15 x 450.0 mm	70-110 A
4.0 x 450.0 mm	90-180 A
5.0 x 450.0 mm	150-250 A