

ESL'ARC - 61



Classification

AWS - E6013. IS : ER 4211
as per IS : 814 - 04

Applications

Structural work; Bridge; Wagons; Tanks;
Pipeline; Ship Building etc.

Characteristics

A medium coated general purpose rutile based mild steel electrode for use in general fabrication and structural work. It has medium penetration, low spatter and slag is easy to detach. The weld deposit is of radiographic quality with sound mechanical properties.

Welding Current (AMPS) AC or (DC \pm , A50)

5.00x450mm	4.00x450mm	3.15 x 450mm	3.15x350mm	2.50x350mm
180-220	140-170	90-120	90-120	70-90

Weld Metal Analysis (Average Value) :

C%	Mn.%	Si%	S%	P%
0.10 Max.	0.35-0.55	0.30 Max.	0.03 Max.	0.03%Max.

Mechanical Properties of Weld Metal (Average Value):

UTS	YS	Elongation %	Charpy 'V' Notch at 0°C
410-540 N/mm2 Min	330 Min. N/mm2	L = 5 d.' 22 Min	47 (J) Min.



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