

ESL'ARC - 61 ®



Classification

Class - A₂ As per IRSM -28-2012

AWS -E 6013

IS - ER4211X AS PER IS : 814-04

Applications

Structural work, Bridges, Wagons, Tanks, Pipeline and Ship Building etc.

Characteristics

A medium coated general purpose rutile base 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 clean, defect free and possesses sound mechanical properties.

Welding Current: (AMPS)D±, A50

5.00x450mm	4.00x450mm	3.15 x 450mm	3.15 x 350mm	2.50x350mm
180-220	140-170	90-120	90-120	70-90

Weld Metal Analysis (Average Value) :

C%	Mn.%	Si%	S%	P%
0.10Max	0.35-0.55	0.30 Max	0.030 Max	0.03%Max.

Typical mechanical properties

UTS	YS	Elongation %	Charpy V Notch at 0°C	Reduction Of Area
410N/mm ² Min	330 Min N/mm ²	L = 5 d. 26 Min	47 J Min	50% Min



Shieldarc Equipment Pvt. Ltd.

Mfg. of ESL'ARC Brand of ELECTRODES

85, Elliot Road, Kolkata - 700 016

Phone : 2229-8347 / 2226-2775

Fax : 91-033-2229-4718

Email : sepl2010@gmail.com