

ESL'ARC - 62

Classification

AWS -E6013; BS : E4322 R11; IS; ERR421 IX

Applications

An ideal electrode for all types of fabrications and general engineering works. Main applications include boilers., pressure vessels, pipelines, ship building, wagon building & sheet metal works etc.



Characteristics

A heavy coated rutile type electrode which deposits crack free and radio graphic quality weld, possessing excellent mechanical properties . It can be used with both AC& DC power sources. The slag is quick freezing & easy to remove.

Welding Current (AMPS) AC or (DC ±, A50)

6.3x450mm	5x450mm	4 x 450mm	3.15x350mm	2.50x350mm
240-390	160-230	120-160	80-130	60-80

Weld Metal Analysis (Average Value) :

C%	Mn.%	Si%	S%	PS%
0.10 Max.	0.35-0.60	0.40 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	330 Min. N/mm2	L = 5d. 22 min	50J min



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