

ESL'ARC - 78



Classification

Class -

A4 as per IRS M:28-2012

AWS -

E7018 : IS : EB 5326 H₂JX

Applications

Recommended applications include high pressure piping, boiler & pressure vessels, blast furnace, pen stocks, loco frames, bridges, cranes etc.

Characteristics

A heavy coated low hydrogen iron powder type electrode that has excellent welding characteristics and gives high purity radiographic quality weld deposits. Specially recommended for high strength weld on mild steel, medium carbon and low alloy steels. Deposition efficiency is 115% approx.

Welding Current (AMPS) AC / DC (D+, A70V)

6.30x450mm	5.00x450mm	4.00 x 450mm	3.15x350mm	2.5x350mm
270 - 340	200 - 250	150 - 200	100 -140	70 -100

All Weld Metal Analysis (Average Value):

C%	Mn.%	Si%	S%	P%
0.12 Max.	1.60 max	0.75 Max	0.035 Max	0.035 Max

All Weld Metal Mechanical Properties (Average Value):

UTS	YS	% of RA	Impact	Elongation L = 5D
510 N/mm ² min	350 Min. N/mm ²	50 min	47 J at -20°C min	26% 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