

ESL'ARC 78-1

Classification

AWS : A 5.1 E7018-1

Applications

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

Characteristics

ESL'ARC 78-1 is a heavy coated low hydrogen iron powder type electrode which gives high purity radiographic quality weld deposits with excellent impact properties at sub zero temperatures. Ideal for welding rigid restrained structures, pressure vessel, carbon steel.

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

6.30x450mm	5.00x450mm	4.00 x 450mm	3.15x350mm	2.5x350mm
250 - 330	190 - 250	130 - 200	90 -150	70-110

Typical chemical composition of all weld metal:

C%	Mn.%	Si%	S%	P%
0.08	1.45	0.40	0.024	0.022

Typical Mechanical Properties of all weld metal

UTS	YS	Impact	Elongation L = 4D
560 N/mm ²	500 N/mm ²	80 J at -46° C	27%



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