

ESL'ARC - 88W



Classification

AWS -

A5.5:E8018 W₂

Class -

D as per IRS M:28-2012

Applications

Welding of normal atmospheric corrosion resistant steels like Corten steel and similar steels which are generally used in chemical, petrochemical and railway wagon and coach building industry.

Characteristics

An iron powder low hydrogen electrode for welding of 80000 psi (55 kg/sq.mm) class tensile strength weather proof steel. This basic coated all position electrode is suitable to weld corten steel or steels of similar composition or having resistance to environmental corrosion and sulphur steam, giving a radiographic quality weld in the process.

Welding Current (AMPS) AC / DC

5.00x450mm	4.00 x 450mm	3.15x450mm	2.50x350mm
150-260	130 - 190	90 -150	70 -110

All Weld Metal Analysis (Average Value):

C%	Mn.%	Si%	Cr%	Ni%	Cu%	S%	P%
0.12 Max	0.50-1.30	0.35-0.80	0.45-0.70	0.40-0.80	0.30-0.75	0.04 Max	0.03 Max

Typical Mechanical Properties :

UTS	YS	Impact	Elongation L = 5D
620 N/mm ²	400 N/mm ²	60 J at -20°C	24%



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