

ESL'ARC -98

Classification

Class -

IS: E63BD126 1395-03

Applications

Fabrication of components made of steels to IS : 2062-II Gr.E410,450 IS : 2002-01 Gr. 3, IS : 1875-04 class 3A or similar, welding of pressure vessels, tanks etc.

Characteristics

A basic coated low hydrogen electrode designed for welding high strength low alloy steel. The weld metal is of radiographic quality.

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

5.00x450mm	4.00x450mm	3.15 x 450mm	3.15x350mm	2.50x350mm
200 - 250	150 - 200	100-140	100 -140	70 -100

Weld Metal Analysis (Average Value) :

C%	Mn.%	Si%	S%	P%	Mo%
0.10 Max.	1.25-1.75	0.80 Max.	0.03 Max.	0.03 Max.	0.25 - 0.45

Mechanical Properties of Weld Metal (Average Value):

UTS	YS	% of RA	Impact	Elongation L = 5D
630 N/mm ² min	530 N/mm ² min	40 min	27 J at - 50°C min	20% Min



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