

# ESL'ARC - 60



## Classification

Class -

AWS : E6012. IS : ER 4124

## Applications

Light fabrication; Sheet metal works;  
Storage tanks; Steel furniture; etc.

## Characteristics

A medium coated general purpose all position mild steel electrode designed for welding of structural work and general fabrication, The electrode has forceful arc and is suitable to bridge up large gaps. It is also ideal for poor fit up application. The slag is quick freezing & easy to remove.

## Welding Current (AMPS) AC or DC :

5.00x450mm	4.00x450mm	3.15 x 450mm	3.15x350mm	2.50x350mm
160-230	120-160	80-130	80-130	60-80

## Weld Metal Analysis (Average Value) :

C%	Mn.%	Si%	S%	PS%
0.10 Max.	0.35-0.55	0.30 Max.	0.03 Max.	0.03%Max.

## Mechanical Properties of Weld Metal (Average Value):

UTS	YS	Elongation %	Charpy 'V' Notch at +27°C	Reduction Of Area
410-540 Min. N/mm2	330 Min. N/mm2	L = 5 d.' 20 Min	47 (J ) Min.	50% Min



## Shieldarc Equipment Pvt. Ltd.

Mfg. of ESL'ARC Brand of ELECTRODES

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