

ESAB FERROWELD 2



A basic coated low-hydrogen electrode for MMAW

Classification AWS A5.1: E 7018
IS: 814 EB 5424H₃JX



DESCRIPTION

ESAB FERROWELD 2 is a basic coated, hydrogen controlled iron powder (high metal recovery of 110%) electrode for welding mild, medium carbon, low alloy, medium tensile steels, free cutting and difficult to weld steels, grey cast iron (non-machinable deposits) in all positions using AC or DC power sources. The addition of iron powder permits higher currents to be used and results in Improved arc characteristics. ESAB FERROWELD 2 allow touch welding and deposit weld metal of highest radiographic soundness free from under-bead cracking and high notch ductility at sub zero temperatures.

APPROVALS

ABS 3H10 3Y, BIS BV 3YHH, CIB, DNV 3YH10, EIL, IRS Gr.3YH, LRS Gr.3, 3Y 3H, MMD, PDIL, RDSO C2 D1 F

WELDING CURRENT: DC±, AC 70V

TYPICAL APPLICATIONS

Boiler and pressure vessels, penstock, structural and other components under restrained conditions and dynamic loading, ship building, steel of doubtful composition, grey cast iron, buffer layer prior to hard facing etc.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.07	Mn	1.20	YS	470 N/mm ²
Si	0.47	S	0.022	UTS	570 N/mm ²
P	0.023			EL (L=5d)	26%
				Impact (CVN) at -30°C	80J

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	70-110	140	560
3.15	450	110-140	90	360
4.00	450	140-185	60	240
5.00	450	160-275	40	160
6.30	450	200-360	25	100

PACKING: Electrodes are packed in cartons and four of these cartons are shrink wrapped in a cardboard box.