

# ESAB FERROSPEED PLUS



## A rutile coated general-purpose electrode for MMAW

Classification AWS A5.1: E 6013  
IS: 814 ER 4211X



### DESCRIPTION

ESAB FERROSPEED PLUS is a medium-heavy coated mild steel welding electrode for all positions, having good mechanical properties and arc characteristics. ESAB FERROSPEED PLUS operates on low open circuit voltage and its good running characteristics result in excellent weld finish of radiographic quality. ESAB FERROSPEED PLUS is also known for its Superior V-down welding capabilities.

### APPROVALS

BIS, BV Gr.2, CIB, IRS Gr.2, LRS Gr.2, MMD,PDIL, EIL

**WELDING CURRENT:** DC±, AC 50V

### TYPICAL APPLICATIONS

ESAB FERROSPEED PLUS is recommended in applications such as bogies and under-frame of railway carriages and wagons, chimneys, construction engineering jobs, pipe welding, sheet metal fabrication, ship building, steel structures and frame works, truck and bus bodies, tanks, boiler components etc.

### TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.08	S	0.02	YS	440 N/mm <sup>2</sup>
Si	0.23	Mn	0.45	UTS	500 N/mm <sup>2</sup>
P	0.02			EL (L=5d)	26%
				Impact (CVN) at + 0°C	70J

### CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.5	350	40-105	190	760
3.15	350	85-135	140	560
3.15	450	85-120	140	560
4.00	350	120-175	85	340
4.00	450	120-160	85	340
5.00	450	160-240	55	220
6.30	450	230-300	40	160

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