



ESAB 36H (SPL) M

A basic coated low-hydrogen MMAW electrode for low temperature & NACE requirements

Classification AWS A5.1: E7018-1

DESCRIPTION

ESAB 36H (SPL) M is a heavy basic coated extra low hydrogen, iron powder, moisture resistant electrode designed for welding in all positions. The electrode meets NACE requirements.

WELDING CURRENT: DC+, AC 70V

TYPICAL PROPERTIES

Weld Metal Composition (Wt.%)		All Weld Mechanical Properties	
C	0.07	YS (N/mm ²)	440
Si	0.30	UTS (N/mm ²)	540
Mn	1.10	Elongation (%)	31
		Impact (CVN) @ -46°C (Joules)	80

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	75-105	140	560
3.15	450	95-150	90	360
4.00	450	140-190	60	240
5.00	450	180-260	40	160

PACKING: Electrodes are packed in cartons and four of these cartons are shrink wrapped in a cardboard box. This electrode can also be made available in moisture resistant vacuum packed cartons, which can be used without redrying.

ESAB C23S

A high recovery rutile-iron powder electrode for SMAW

Classification AWS A5.1: E7024
IS 814: ERR5234KX

DESCRIPTION

ESAB C23S is a heavy coated rutile-iron powder electrode having a metal recovery of 130-140%. It is specially designed for very fast welding of unalloyed steels in downhand position and for standing fillets by contact welding.

APPROVALS: BV & IRS

WELDING CURRENT: DC_±, AC 70V

TYPICAL PROPERTIES

Weld Metal Composition (Wt.%)		All Weld Mechanical Properties	
C	0.08	YS (N/mm ²)	460
Si	0.40	UTS (N/mm ²)	550
Mn	0.80	Elongation (%)	22
		Impact (CVN) @ 0°C (Joules)	60

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
3.15	450	70-120	75	300
4.00	450	70-130	55	220
5.00	450	120-250	30	120

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



ESAB FERROWELD 1

A basic coated low hydrogen electrode for SMAW

Classification AWS A5.1: E7016
IS 814: EB5424H₃X

DESCRIPTION

ESAB FERROWELD 1 is a basic coated, hydrogen controlled electrode for welding mild, medium tensile, low alloy, free cutting and difficult to weld steels and grey cast iron (non-machinable deposits) in all positions, using AC or DC. The composition of coating ensures complete absence of porosity and cracking.

WELDING CURRENT : DC_±, AC 70V

TYPICAL PROPERTIES

Weld Metal Composition (Wt.%)		All Weld Mechanical Properties	
C	0.06	YS (N/mm ²)	450
Si	0.70	UTS (N/mm ²)	540
Mn	1.00	Elongation (%)	32
		Impact (CVN) @ -30°C (Joules)	60

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	75-105	170	680
3.15	450	95-150	100	400
4.00	450	140-190	65	260
5.00	450	190-260	45	180

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

ESAB 36H

A basic coated low hydrogen electrode for SMAW

Classification AWS A5.1: E7018
IS 814: EB5426H₃JX

DESCRIPTION

ESAB 36H is a heavy basic coated, hydrogen controlled iron powder electrode designed for welding in all positions. It gives tough, crack resistant weld on mild and low alloy steels. ESAB 36H deposits good radiographic quality welds and is ideal for welding restraint structures where stresses can not be avoided.

APPROVALS: ABS, BV, DNV, IBR, IRS, LRS, MMD, NPC, PDIL & TOYO

WELDING CURRENT: DC₊, AC 70V

TYPICAL PROPERTIES

Weld Metal Composition (Wt.%)		All Weld Mechanical Properties	
C	0.07	YS (N/mm ²)	470
Si	0.35	UTS (N/mm ²)	540
Mn	1.25	Elongation (%)	28
		Impact (CVN) @ -30°C (Joules)	100

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	60-100	130	520
3.15	450	70-130	90	360
4.00	450	90-200	60	240
5.00	450	110-280	40	160

PACKING: Electrodes are packed in cartons and four of these cartons are shrink wrapped in a cardboard box. This electrode can also be made available in moisture resistant vacuum packed cartons, which can be used without redrying.