



Characteristics

Medium coated, cellulosic electrode, especially designed for use in AC as well as DC. Due to its high penetration, it is suitable for root pass and fill passes in vertical down direction. Used in shipbuilding, storage vessels, boilers, pipeline constructions, assembly and repair works in mild steels, steel casting, galvanized sheets and machinery parts. AC or DCEN (-) is ideal in root passes and AC or DCEP (+) is recommended for fill and cap passes in

Base Material



Typical applications

Typical Analysis in %

Used in shipbuilding, storage vessels, boilers, pipeline constructions, assembly and repair works in mild steels, steel casting, galvanized sheets and machinery

	%C	%Mn	%Si	%S	%P
Typical Chemical Analysis	0.10	0.60	0.20		
	%Cr	%Ni	%Mo	%Cu	%Ti

Mechanical Properties as required per AWS A5.28 ER100S-1

	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elongation A5 %	Impact Energy J
Typical Results (all weld metal)				
As Welded	470 mpa	530 mpa	24	-30C >27 J -20C 50 J

Ordering Information

Article Number	Product	Dimension	Packaging
1146110M15	ESC 61 (E6011)	2.5x350mm(3/32X14")	3X5 KG (3X11 lb) Cardboard
1146116M15	ESC 61 (E6011)	3.25X350mm(1/8X14")	3X5 KG (3X11 lb) Cardboard
1146120M15	ESC 61 (E6011)	4.0X350mm(5/32X14")	3X5 KG (3X11 lb) Cardboard
1146128M15	ESC 61 (E6011)	5.0X350mm(3/16X14")	3X5kg (3X11 lb) Cardboard