

ESC 61

Cellulosic Coated Electrode - Non Alloyed Steels

Standards

AWS/ASME SFA - 5.1	E6011
EN ISO 2560 - A	E 35 2 C 21
TS EN ISO 2560 - A	E 35 2 C 21

Approvals & Certificates

CE CWB

Properties and Applications

Medium coated, cellulosic electrode, especially designed for use in AC, as well as in 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 vertical down direction.



Typical Chemical Values of Weld Metal

Type of Analysis	C	Si	Mn
Weld Deposit	0.12	0.20	0.55

Typical Mechanical Values of Weld Metal

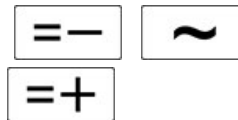
Test Condition	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	470	530	24	-20°C → 50

Application Information

Welding Positions



Polarity:



Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
4.00x350	120-170
5.00x350	160-200
3.25x350	70-130
2.50x350	60-100

Packaging Information

Product Code	Diameter X Length (mm)	Pieces per Box (-)	Weight Of The Box (kg)	Boxes Per Package	Weight Of The Package	Packaging Type
11402HREM2	2.50x350	299 kg	5.0	3	15.4	Cardboard Box
11402NREM2	3.25x350	181 kg	5.0	3	15.4	Cardboard Box
11402QREM2	4.00x350	117 kg	5.0	3	15.4	Cardboard Box
11402TREM2	5.00x350	73 kg	5.0	3	15.4	Cardboard Box

Storage & Re-Drying Information

Don't redry.