

# ESH 160R

High Efficiency Coated Electrode - Non Alloyed Steels

## Standards

AWS/ASME SFA - 5.1	E7024
EN ISO 2560 - A	E 42 A RR 73
TS EN ISO 2560 - A	E 42 A RR 73

## Properties and Applications

Suitable for welding of large sections and fillets in shipbuilding with it's 165% recovery. Produces very smooth, concave and clean welds, merging into base metal without undercuts. Suitable for welding prepainted plates. Easy arc striking and restriking. Slag is self-releasing in most cases.

## Approvals & Certificates

CE TUV

## Materials

EN	DIN
S185 - S275J2	St 33- St 44.3
P235GH, P265GH	H I, H II
P295GH	17Mn4
S255N - S355N	StE 255 - StE 355
GE 200, GE 240, GE 260	GS 38, GS 45, GS 52
	AH 32, EH 36
	A, B, D

## Typical Chemical Values of Weld Metal

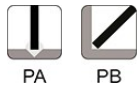
Type of Analysis	C	Si	Mn
Weld Deposit	0.10	0.65	1.05

## Typical Mechanical Values of Weld Metal

Test Condition	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	530	580	24	20°C → 50

## Application Information

### Welding Positions



### Polarity:



### Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
2.50x350	70-110
4.00x450	160-220
5.00x450	220-300
6.00x450	300-360
3.25x450	100-170

## 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
11120HREM2	2.50x350	158 pcs	5.0	3	15.4	Cardboard Box
11120PSEM2	3.25x450	89 pcs	6.5	3	19.9	Cardboard Box
11120SSEM2	4.00x450	57 pcs	6.5	3	19.9	Cardboard Box
11120VSEM2	5.00x450	38 pcs	6.5	3	19.9	Cardboard Box
11120XSEM2	6.00x450	28 pcs	6.5	3	19.9	Cardboard Box

### Storage & Re-Drying Information

Generally not required. If required, redry for 1 hour at 110°C.