

ESC 60

Selülozik Örtülü Elektrod - Non Alloyed Steels

Standards

AWS/ASME SFA - 5.1	E6010
EN ISO 2560 - A	E 42 2 C 21
TS EN ISO 2560 - A	E 42 2 C 21

Approvals & Certificates

ABS	BV	CWB
DB	TSE	TUV
CE		

Applications

Medium coated, cellulosic electrode, especially designed for welding of pipes and plates in all positions at low welding currents. Due to its high penetration, particularly suitable for root pass and fill passes in vertical down direction. Used in pipe-line construction, shipbuilding, storage vessels and assembly works. DCEN (-) is ideal in root passes and DCEP (+) is recommended for fill and cap passes in vertical down position.

Typical Mechanical Values of Weld Metal

Test Condition	Akma Dayanımı (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)	
As Welded	470	530	25	-20°C → 60	-30°C → 40

Application Information

Welding Positions



Polarity:



Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
2.50x350	40-80
3.25x350	60-120
4.00x350	80-150
5.00x350	120-190

Packaging Information

Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (Kg)	Boxes per Outer Box	Outer Box Gross Weight (Kg)	Packaging Type
1141010M15	2.50x350	285 AD	5.06	3	15.30	Cardboard Box
1141010M46	2.50x350	455 AD	8.27	1	8.30	Tin Box
1141016M15	3.25x350	168 AD	5.06	3	15.30	Cardboard Box
1141016M46	3.25x350	269 AD	8.27	1	8.30	Tin Box
1141020M15	4.00x350	112 AD	5.06	3	15.30	Cardboard Box
1141020M46	4.00x350	178 AD	8.27	1	8.30	Tin Box
1141028M15	5.00x350	71 AD	5.06	3	15.30	Cardboard Box
1141028M46	5.00x350	114 AD	8.27	1	8.30	Tin Box

Storage & Re-Drying Information