

ESC 60

Cellulosic Coated Electrode - 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		
CWB	CE	TUV
DB	TSE	BV

Properties and 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 Chemical Values of Weld Metal

Type of Analysis	C	Si	Mn
Weld Deposit	0.12	0.20	0.60

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	25	-20°C → 60	-30°C → 40

Application Information

Welding Positions



Polarity:



Welding Parameters & Efficiency

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

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
11400HREM2	2.50x350	285 kg	5.0	3	15.3	Cardboard Box
11400HZTM2	2.50x350	455 kg	8.0	2	8.3	Tin Box
11400NQEM2	3.25x350	84 kg	2.5	6	15.4	Cardboard Box
11400NREM2	3.25x350	168 kg	5.0	3	15.3	Cardboard Box
11400NZTM2	3.25x350	269 kg	8.0	2	8.3	Tin Box

11400QREM2	4.00x350	112 kg	5.0	3	15.3	Cardboard Box
11400QZTM2	4.00x350	178 kg	8.0	2	8.3	Tin Box
11400TREM2	5.00x350	71 kg	5.0	3	15.3	Cardboard Box
11400TZTM2	5.00x350	114 kg	8.0	2	8.3	Tin Box

Storage & Re-Drying Information

Don't redry.