

# ES EST

Type Basic

SMAW

EST

**ESWECO**  
*The Art of Welding*

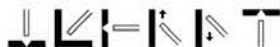
## Description

ES EST is a non-nickel, non machinable cast iron electrode. It is the most economical way to go for repairing various kinds of cast iron products providing that machinability of the weld deposit is not required and where weld shrinkage stress is not a concern.

EST melts at relatively low temperatures which permit the use of low welding currents. This electrode may be used in any position utilizing AC or DC (reverse polarity).

## Current

AC, DC+ OCV 50 V



## Classifications

SFA/AWS A5.15 EST

## Typical all weld metal composition, %

C	Si	Mn	P	Fe
1.68	0.5	0.35	0.016	Bal.

## Typical mech. Properties all weld metal

Yield stress, MPa	380
Tensile strength, MPa	490
Elongation, A5 %	33
Hardness, HRC	16

## Welding parameters

Diameter, mm	Length, mm	Welding current, A
2.5	350	60-90
3.2	350	90-130
4.0	450	130-180
5.0	450	150-200