

ES 47.00

SMAW

ESWECO
The Art of Welding

Type Lime-basic

E7016-1

Description

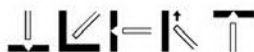
ES 47.00 is an extra-high quality LMA electrode, particularly suitable for on-site welding. ES 47.00 yields a homogeneous, high-quality weld metal with an extra low content of impurities. The electrode operates well on AC as well as DC positive and negative. DC negative is preferred, as it produces a small, easily controlled weld pool, minimising the risk of burn-through or undercutting.

Recovery

100%

Current

AC, DC + (-) OCV 65 V



Classifications

| | |
|--------------|----------------|
| SFA/AWS A5.1 | E7016-1 |
| EN 499 | E 42 5 B 12 H5 |

Typical all weld metal composition, %

| C | Si | Mn |
|------|-----|-----|
| 0.06 | 0.4 | 1.3 |

Typical mech. Properties all weld metal

| | |
|-----------------------|---------|
| Yield stress, MPa | >420 |
| Tensile strength, MPa | 510-640 |
| Elongation, % | 26 |

Charpy V

| | |
|----------------|------------------|
| Test temps, °C | Impact values, J |
| -20 | 150 |
| -40 | 80 |
| -50 | 47 |

Welding parameters

| Diameter, mm | Length, mm | Welding current, A | Arc voltage, V |
|--------------|------------|--------------------|----------------|
| 2.5 | 350 | 55-85 | 22 |
| 3.2 | 450 | 80-130 | 22 |
| 4.0 | 450 | 110-170 | 22 |
| 5.0 | 450 | 180-230 | 22 |