

ES 32.04

Type Rutile

SMAW

Gr.2Y

ESWECO
The Art of Welding

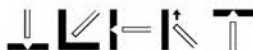
Description

ES 32.04 is medium coated general purpose mild steel electrode, especially designed for use in vertical and fillet weld positions. This is a rutile coated electrode with fast freezing slag and slag detachability even in deep grooves.

It is suitable for welding mild steel plate, sheets metal and galvanized iron sheet, ducting, hoppers, tanks, pipes and low pressure pipelines. Excellent for welding joints with poor fit-up.

Welding current

AC, DC + (-)



Classifications

EN ISO 2560-A E 42 0 RC 13

Typical all weld metal composition, %

C	Si	Mn
0.07	0.4	0.8

Typical mech. Properties all weld metal

Yield stress, MPa	420
Tensile strength, MPa	530
Elongation, %	24

Charpy V

Test temps, °C	Impact values, J
0	70

Approvals

LR Grade 2Y

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	350	80-110	22
3.2	350	100-140	22
4.0	350	140-180	22