

FERROCRAFT 61
55
OCV

DC
AC

- ▲ Basic Coated, Hydrogen Controlled E4818 / E7018 Type Electrode.
- ▲ Superb AC/DC Operator Appeal.
- ▲ Excellent Out-of-Position Welding.
- ▲ Reliable Impact Properties to -30°C.
- ▲ BATCH NUMBER Identification.

Classifications:

AS /NZS 1553.1: (old) E4818-3 H10.
 AS/NZS 4855: (new) B E4918 A U H10
 AWS/ASME-SFA A5.1: E7018.

Description and Applications:

Ferrocraft 61 is the latest smooth running, user friendly hydrogen controlled electrode from CIGWELD. Ferrocraft 61 gives improved side wall wash and reduced undercut at weld toes and produces very low spatter levels for an electrode of its type. Fillet weld shape is excellent and exhibits a true mitre to slightly convex profile.

Improved arc characteristics and stability on low Open Circuit Voltage welding machines (≥ 55 O.C.V.) ensure Ferrocraft 61 has the high operator appeal Welders demand from today's manual arc electrodes.

Ferrocraft 61 is specifically designed for all positional (especially vertical-up) fillet and butt welding applications on heavier steel sections under high restraint such as machinery parts, pressure vessels, mining equipment, pipework, ship construction and all maintenance and repair work; on site, in the workshop or on the land.

Packaging and Operating Data:

AC (minimum 55 O.C.V.), DC+ or DC- polarity.

Electrode		Approx No.	Current	Packet	Carton	Part No
Size mm	Length mm	Rods/kg	Range (amps)			
2.5	300	42	70-110	5kg	15kg - 3 x 5kg	611342
3.2	350	24	110-150	5kg	15kg - 3 x 5kg	611343
4.0	350	16	150-200	5kg	15kg - 3 x 5kg	611344
5.0	400	9	190-260	5kg	15kg - 3 x 5kg	611345

- Ferrocraft 61 is formulated to operate with AC (55 O.C.V min), DC+ or DC- polarity. The preferred polarity for fillet welding and fill and capping passes is DC+.

APPROVALS:

Det Norske Veritas Grade 3YH5.

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Yield Stress. 450 MPa.
 Tensile Strength 545 MPa.
 Elongation 29%.
 CVN Impact Values 160 J av @ -20°C.
 130 J av @ -30°C.

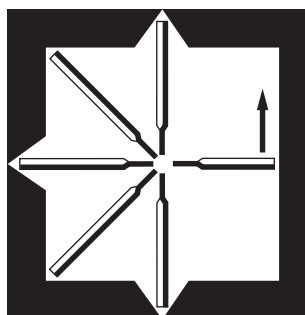
TYPICAL ALL WELD METAL ANALYSIS:

C: 0.06% Mn: 1.45% Si: 0.45%
 S: 0.010% P: 0.012%

TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

8.5 - 9.0 mls of hydrogen / 100gms of deposited weld metal *.

* Reconditioned for 2 hours maximum @ 300°C.



All positional -
except vertical down