

## FERROCRAFT 61



- ▲ 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: E4818-3 H10.  
AWS/ASME-SFA A5.1: E7018.

## Description and Applications:

Ferrocrafft 61 is the latest smooth running, user friendly hydrogen controlled electrode from CIGWELD. Ferrocrafft 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 ( $\geq 55$  O.C.V.) ensure Ferrocrafft 61 has the high operator appeal Welders demand from today's manual arc electrodes.

Ferrocrafft 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.

## APPROVALS:

|                              |                 |
|------------------------------|-----------------|
| Lloyd's Register of Shipping | Grade 3, 3YH15. |
| American Bureau of Shipping  | Grade 3H15, 3Y. |
| Det Norske Veritas           | Grade 3YH10.    |
| American Bureau of Shipping  | AWS A5.1 E7018. |

## 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. |

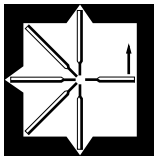
## TYPICAL ALL WELD METAL ANALYSIS:

|           |           |           |
|-----------|-----------|-----------|
| 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

## Packaging and Operating Data:

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

| Size mm | Electrode |  | Approx No. Rods/kg | Current Range (amps) | Packet | Carton         | Part No |
|---------|-----------|--|--------------------|----------------------|--------|----------------|---------|
|         | Length mm |  |                    |                      |        |                |         |
| 2.5     | 350       |  | 42                 | 65-100               | 5kg    | 15kg - 3 x 5kg | 611342  |
| 3.2     | 380       |  | 24                 | 95-150               | 5kg    | 15kg - 3 x 5kg | 611343  |
| 4.0     | 380       |  | 16                 | 145-220              | 5kg    | 15kg - 3 x 5kg | 611344  |
| 5.0     | 450       |  | 9                  | 195-270              | 5kg    | 15kg - 3 x 5kg | 611345  |

# - Ferrocrafft 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+.