

ESB 44

Basic Coated Electrode - Non Alloyed Steels

Standards	
AWS/ASME SFA - 5.1	E7016 H8
EN ISO 2560 - A	E 42 3 B 12 H10
TS EN ISO 2560 - A	E 42 3 B 12 H10

Approvals & Certificates		
CE-DoP UKCA-DoP TSE	CE DNV DB	UKCA TUV

Materials	
EN	DIN
S185 - S355J0	St 33- St 52.3
P235GH, P265GH	H I, H II
P295GH	17Mn4
P235TR2 - P355T2	St37.4 - St 52.4
P235G1TH, P255G1TH	StE 35.8 - StE 45.8
L210 - L360NB	StE 210.7 - StE 360.7
S255N - S355N	StE 255- StE 355
GE 200, GE 240, GE 260	GS 38, GS 45, GS 52
	AH 32, EH 36
	A, B, D, E

Properties and Applications

Suitable for fabrication and repair welding of dynamically loaded steel constructions, machines and agricultural equipments, workshop and maintenance welding. Smooth and clean welds, blending into base metal without undercuts. Excellent gap bridging properties. The double covering of this electrode produces a stable, concentrated and directed arc, thus being ideally suited for root pass and positional welding and is suited for AC welding. Welds are of X-ray quality.



Typical Chemical Values of Weld Metal

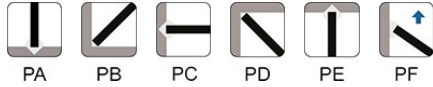
Type of Analysis	C	Si	Mn
Weld Deposit	0.06	0.65	1.10

Typical Mechanical Values of Weld Metal

Test Condition	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)	
As welded	450	550	25	-20°C → 70	-30°C → 55

Application Information

Welding Positions



Polarity:



Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
2.50x350	60-90
4.00x450	130-180
3.25x450	70-130
5.00x450	180-250
3.25x350	70-140
2.00x350	40-60
4.00x350	130-180

Packaging Information

Product Code	Diameter X Length (mm)	Pieces per Box (-)	Weight Of The Box (kg)	Boxes Per Package	Weight Of The Package	Packaging Type
11202EREM2	2.00x350	394	5.0	3	15.4	Cardboard Box
11202HBEM2	2.50x350	50	1.0	12	13.8	Plastic Box
11202HKEM2	2.50x350	126	2.5	6	15.6	VAC Box
11202HQEM2	2.50x350	126	2.5	6	15.4	Cardboard Box
11202HREM2	2.50x350	251	5.0	3	15.4	Cardboard Box
11202NBEM2	3.25x350	30	1.0	12	13.5	Plastic Box
11202NKEM2	3.25x350	76	2.5	6	15.5	VAC Box
11202NQEM2	3.25x350	76	2.5	6	15.4	Cardboard Box
11202NREM2	3.25x350	151	5.0	3	15.4	Cardboard Box
11202PKEM2	3.25x450	59	2.5	6	15.6	VAC Box
11202PSEM2	3.25x450	153	6.5	3	19.9	Cardboard Box
11202QBEM2	4.00x350	20	1.0	10	11.3	Plastic Box
11202QKEM2	4.00x350	49	2.5	6	15.5	VAC Box
11202SBEM2	4.00x450	15	1.0	10	11.3	Plastic Box
11202SKEM2	4.00x450	37	2.5	6	15.6	VAC Box
11202SSEM2	4.00x450	97	6.5	3	19.9	Cardboard Box
11202VKEM2	5.00x450	25	2.5	6	15.6	VAC Box
11202VSEM2	5.00x450	64	6.5	3	19.9	Cardboard Box

Storage & Re-Drying Information

It can be dried maximum 5 times.
It has to be dried at 350°C for 2 hours.