

Classification Of Surfacing Electrodes As Per AWS A5.13-2000

E FeMnCr



	Symbol	Chemical Composition %										
		C	Mn	Si	Cr	Ni	Mo	V	W	Other	Fe	Other Elements Total
Iron Base Surfacing Electrodes	EFe1	0.04-0.20	0.5-2.0	1.0	0.5-3.5	-	1.5	-	-	-	Rest	1.0
	EFe2	0.10-0.30	0.0-2.0	1.0	1.8-3.8	1.0	1.0	0.35	-	-	Rest	1.0
	EFe3	0.50-0.80	0.5-1.5	1.0	4.0-8.0	-	1.0	-	-	-	Rest	1.0
	EFe4	1.0-2.0	0.5-2.0	1.0	3.0-5.0	-	-	-	-	-	Rest	1.0
	EFe5	0.30-0.80	1.5-2.5	0.90	1.5-3.0	-	7.0-9.5	0.5-1.5	0.5-1.5	-	Rest	1.0
	EFe6	0.6-1.0	0.4-1.0	1.0	3.0-5.0	-	7.0-9.5	0.5-1.5	0.5-1.5	-	Rest	1.0
	EFe7	1.5-3.0	0.5-2.0	1.5	4.0-8.0	-	1.0	-	-	-	Rest	1.0
	EFeMn-A	0.5-1.0	12-16	1.3	-	2.5-5.0	-	-	-	-	Rest	1.0
	EFeMn-B	0.5-1.0	12-16	1.3	-	-	0.5-1.5	-	-	-	Rest	1.0
	EFeMn-C	0.5-1.0	12-16	1.3	2.5-5.0	2.85-5.0	-	-	-	-	Rest	1.0
	EFeMn-D	0.5-1.0	15-20	1.3	4.5-7.5	-	-	0.4-1.2	-	-	Rest	1.0
	EFeMn-E	0.5-1.0	15-20	1.3	3.0-6.0	1.0	-	-	-	-	Rest	1.0
	EFeMn-F	0.8-1.2	17-21	1.3	3.0-6.0	1.0	-	-	-	-	Rest	1.0
	EFeMnCr	0.25-0.75	12-18	1.3	13-17	0.5-2.0	2.0	1.0	-	-	Rest	1.0
	EFeCr-A1-A	3.5-4.5	4.0-6.0	0.5-2.0	20-25	-	0.5	-	-	-	Rest	1.0
	EFeCr-A2	2.5-3.5	0.5-1.5	0.5-1.5	7.5-9.0	-	-	-	-	Ti 1.2-1.8	Rest	1.0
	EFeCr-A3	2.5-4.5	0.5-2.0	1.0-2.5	14-20	-	1.5	-	-	-	Rest	1.0
	EFeCr-A4	3.5-4.5	1.5-3.5	1.5	23-29	-	1.0-3.0	-	-	-	Rest	1.0
	EFeCr-A5	1.5-2.5	0.5-1.5	2.0	24-32	4.0	4.0	-	-	-	Rest	1.0
	EFeCr-A6	2.5-3.5	0.5-1.5	1.0-2.5	24-30	-	0.5-2.0	-	-	-	Rest	1.0
	EFeCr-A7	3.5-5.0	0.5-1.5	0.5-2.5	23-30	-	2.0-4.5	-	-	-	Rest	1.0
	EFeCr-A8	2.5-4.5	0.5-1.5	1.5	30-40	-	2.0	-	-	-	Rest	1.0
	EFeCr-E1	5.0-6.5	2.0-3.0	0.8-1.5	12-16	-	-	-	-	Ti 4.0-7.0	Rest	1.0
EFeCr-E2	4.0-6.0	0.5-1.5	1.5	14-20	-	5.0-7.0	1.5	-	-	Rest	1.0	
EFeCr-E3	5.0-7.0	0.5-2.0	0.5-2.0	18-28	-	5.0-7.0	-	3.0-5.0	-	Rest	1.0	
EFeCr-E4	4.0-6.0	0.5-1.5	1.0	20-30	-	5.0-7.0	0.5-1.5	2.0	Nb 4.0-7.0	Rest	1.0	
Nickel and Cobalt Base Surfacing Electrodes	ECoCr-A	0.7-1.4	2.0	2.0	25-32	3.0	1.0	5.0	3.0-6.0	-	Rest	1.0
	ECoCr-B	1.0-1.7	2.0	2.0	25-32	3.0	1.0	5.0	7.0-9.5	-	Rest	1.0
	ECoCr-C	1.7-3.0	2.0	2.0	25-33	3.0	1.0	5.0	11-14	-	Rest	1.0
	ECoCr-E	0.15-0.4	1.5	2.0	24-29	2.0-4.0	4.5-6.5	5.0	0.50	-	Rest	1.0
	ENiCr-C	0.5-1.0	-	3.5-5.5	12-18	Rest	-	3.5-5.5	-	B 2.5-4.5	1.0	1.0
	ENiCrMo-5A	0.12	1.0	1.0	14-18	Rest	14-18	4.0-7.0	3.0-5.0	V 0.40	-	1.0
	ENiCrFeCo	2.2-3.0	1.0	0.6-1.5	25-30	10-33	7.0-10	20-25	2.0-4.0	-	10-15	1.0

Email : sales@ferrsol.com | Web : www.ferrsol.com

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