



ESH 180R



High strength cellulosic electrode for pipe welding. **AWS/ASME SFA 5.1 E7024**

Key Characteristics

- Heavy coated rutile high efficiency electrode having weld metal recovery of approx. 180%.
- It is suited to produce long fillet welds and economically filling up large weld joints especially in shipbuilding.
- Relatively low current intensities and short burn of times, easy arc striking and restriking.

Base Material



Typical Applications

- Suitable for joining and repair welding of light steel fabrications, iron works, wrought iron work.
- Suitable to use in pre painted plates

Typical Chemical Composition

Typical Chemical Analysis	%C	%Mn	%Si	%S	%P
Typical Chemical Analysis	0.07	0.65	0.55		
Typical Chemical Analysis	%Cr	%Ni	%Mo	%Cu	%Ti

Mechanical Properties

	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elongation (%)	Impact Energy (J)
Typical Results (all weld metal) As Welded	460 MPa	530 MPa	25	-20°C → 50J

Ordering Information

Product Code	Product/AWS Specification	Dimension mm/inches	Single Pack Weight kg/lb	Box Weight kg/lb
1119518M15	ESH 180R (E7024)	3.25 mm x 450 mm (1/8" x 18")	6.5 kg (14.3 lb)	19.5 kg (43.0 lb)
1119524M15	ESH 180R (E7024)	4.0 mm x 450 mm (5/32" x 18")	6.5 kg (14.3 lb)	19.5 kg (43.0 lb)
1119532M15	ESH 180R (E7024)	5.0 mm x 450 mm (3/16" x 18")	6.5 kg (14.3 lb)	19.5 kg (43.0 lb)

