



Support Roller Buildup

## Moisture resistant electrode for welding low alloy and high tensile steels

### Typical Applications:

Crane jibs, frames, truck chassis, heavy equipment maintenance.

### Outstanding Features:

- Low hydrogen electrode with non-hygroscopic coating.
- Suitable for cast steels containing Sulphur.
- High arc force purges out impurities.
- High tensile, ductility and crack resistance. Anti-spalling under extreme pressure.
- X-ray quality weld deposits.

### Recommendation:

For medium carbon steel, low alloy and high tensile steel, 'problem' steel and structural steel sections. Elements like Sulphur, Phosphorous etc. which produce porosity are purged from molten pool by electrode arc action.

### Procedure:

Clean weld area. Maintain medium to short arc length. Horizontal fillet welds can be made using the contact technique. Vertical joints should be welded from the bottom up by weaving rapidly. Do not whip. Slag is easily removed by chipping.

### Recommended Amperages:

Size (mm)	I - Range	II - Range
2.50	70-80	60-70
3.15	120-135	100-115
4.00	150-165	135-150
5.00	185-200	165-185

**Tensile Strength:** 560 MPa (81,000 psi)