Swing Gear

A high alloy electrode for welding dissimilar steel and unknown steels

Typical Applications:

Chassis frames, gears, springs, tool steels, dissimilar alloy steels joining.

Outstanding Features:

- Very high tensile strength and ductility.
- Easy strike and re-strike.
- "Cold arc" coating leading to low heat input.
- Superior for joining dissimilar steels.
- Outstanding resistance to shock & impact.
- Easy Slag removal.
- High frictional wear resistance.

Recommendation:

For high strength welds & overlays on all steels requiring best possible properties. For leaf and coil springs, Vanadium - Molybdenum spring steels, mild steel, medium carbon steels and dissimilar steels.

Procedure:

Clean weld area and ensure joint preparation. For certain high alloy steels, preheat up to 150^{0}C is recommended. Hold a short arc. Run stringer beads. Intermittent welding may be used specially on high alloy steels. Cool each pass before chipping slag. Maintain heat build-up max 300^{0}C.

Recommended Amperages:

Size (mm)	I - Range	II - Range
2.50	60-70	50-60
3.15	90-100	75-90
4.00	110-140	90-110
5.00	160-180	150-160

Tensile Strength: 850 MPa (1,20,000 psi)