Boom Crack

Electrode for high strength joining of Mn steel, low alloy steel & medium carbon steel.

Typical Applications:

Buckets, boom, stick, C frame & undercarriage components of earthmoving equipment.

Outstanding Features:

- Low heat input.
- Compatibility with wide range of steels.
- High ductility.
- Excellent crack resistivity.

Recommendation:

For welding of similar and dissimilar combinations of low-medium carbon steels, low alloy steels, joining with manganese steels, etc. as encountered in construction and mining industry.

Procedure:

Clean weld area. Remove all fatigued or cracked metal. Bevel heavy sections 60°-90° vee. Use short arc to deposit stringer beads. Chip slag between passes. Peen deposits in crack-sensitive applications. Prevent localised heat build-up by staggered welding. When welding do not allow job temperature to exceed 150°C especially for Mn Steel.

Recommended Amperages:

Size (mm)	Amperage
3.15	55 - 100
4.00	85 - 140
5.00	135 - 185

Tensile Strength: 58 Kg/mm^2 (84,000 psi)