

High Strength Electrode for Joining and Repair of Cast Steels and HSLA Steels

Typical Applications :

Hammer bases, columns, rams, sow blocks, keyways, kiln shell.

Outstanding Features :

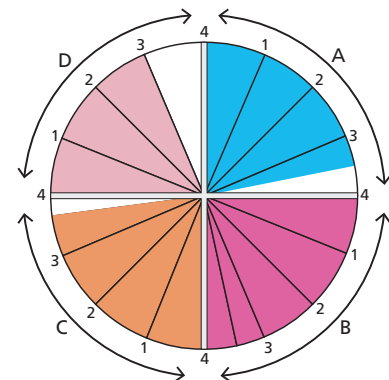
- Non-hygroscopic flux coating
- Strong, stable arc
- Self releasing slag
- No temper embrittlement of weld
- Deposit has very high creep resistance property



Kiln Shell Joining

Welding Procedure:

Clean weld area. Remove fatigued or cracked metal. Bevel all edges 60°. For heavy sections, pre-heat 250° - 300° C. Weld with short arc gap and electrode tilted 10° in travel direction. Use 'stringer bead' deposition, chip slag between passes and peen weld beads. After completion, retard cooling by covering with sand, asbestos etc. For large assemblies and for forging equipment, stress relieving at 550°C - 600°C for one hour per inch job thickness recommended.



- A - Mechanical Strength 3½
- B - Crack resistance 4
- C - Versatility 3¾
- D - Moisture resistance 3

Recommendations :

Joining, build-up and repair of new, worn-out or cracked steel structures, machinery components and other heavy duty equipment & welding of cast steels, fabrication of microalloyed and HSLA steels including automotive applications. Speciallysuited for repair of forging equipment like columns, sow blocks etc.

Recommended Amperage:

Size (mm)	Amperage
3.15	90 - 130
4.00	120 - 160
5.00	150 - 190

Tensile strength: 67 kg/mm² (96,000 psi)

