

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

Welding 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 specially for manganese steel.

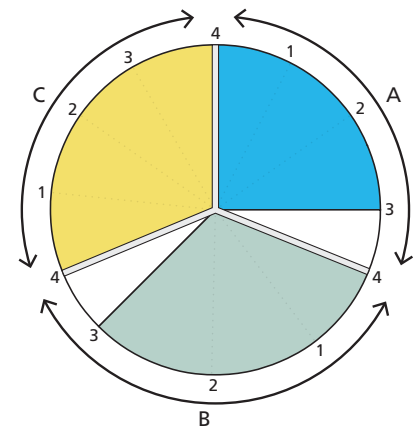
Recommendations :

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.

Tensile Strength : 59 kg/mm² (84,000 psi)



Boom Crack



- A - Mechanical Strength 3
- B - Crack resistance 3
- C - Weldability 4

Recommended Amperage:

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

