

Ideal Electrode for Joining and Over Laying Applications of Wide Range Stainless Steel and Mild Steel Base Material with Superior Oxidation and Heat Resistance Property

Typical Applications :

Valves, tanks, heat exchangers, heat treating boxes and baskets.

Outstanding Features :

- Ideal for oxidation and heat resistance
- Ideal for joining of stainless steel of unknown composition
- Smooth, rapid, spatter-free deposition

Welding Procedure:

Clean weld area. Tack at short intervals when jigs are not available. Square butt weld thickness upto 10mm. Heavier sections should be bevelled to 60°. Maintain short arc and deposit stringer beads. Avoid weaving. Deposit a number of light beads. Use an intermittent welding sequence to prevent overheating. Remove slag. Use electrode positive with dc machine. Minimum open circuit voltage for ac:55 V.

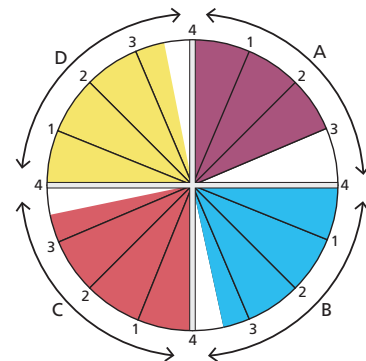
Recommendations :

Excellent weldability, no spatter, high strength and elongation for 25/20 type stainless steel and other unknown stainless steels. Designed for applications requiring a high degree of oxidation resistance and high strength at temperatures up to 1000°C. Used also for welding stainless steel to mild steel.

Tensile Strength : 69 kg/mm² (97,500 psi)



Coal Burner Nozzle



A - Corrosion resistance	3
B - Mechanical Strength	3½
C - Heat resistance	3¾
D - Weldability	3¾

Recommended Amperage:

Size (mm)	I - Range	II - Range
2.50	60 - 70	40 - 50
3.15	85 - 100	55 - 75
4.00	115 - 135	80 - 105

