

Moisture Resistant Electrode to Weld Low Alloy and High Tensile Steels

Typical Applications :

Crane jibs, frames, truck chassis, heavy equipment maintenance.

Outstanding Features :

- Electrode with non-hygroscopic coating
- Suitable for cast steels containing sulphur and phosphorous especially added by OEM for better castability / machinability
- High arc force purges out impurities
- High tensile, ductility and crack resistance.
- X-ray quality weld deposits



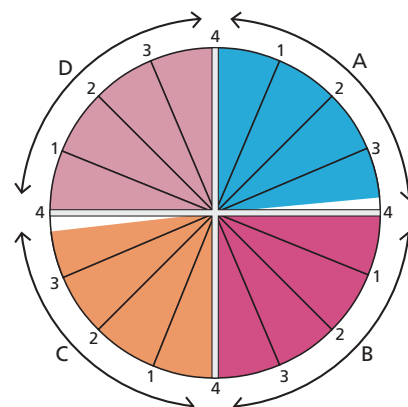
Boom of Excavator

Welding Procedure:

Clean weld area. Maintain medium to short arc length. Horizontal fillet welds can be made using the contact (drag) technique. Vertical joints should be welded from the bottom up by weaving rapidly. Do not whip. Slag is easily removed by chipping.

Recommendations :

For medium carbon steel, low alloy and high tensile steel, 'problem' steel and structural steel sections. Elements like sulphur, phosphorous etc. which produce porosity are purged from molten pool by electrode arc action.



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

Tensile Strength : 58 kg/mm² (82,500 psi)

Recommended Amperages:

Size (mm)	I - Range	II - Range
2.50	70 - 80	60 - 70
3.15	120 - 135	100 - 115
4.00	150 - 165	135 - 150
5.00	185 - 200	165 - 185

