

Applications

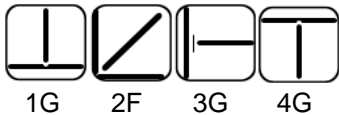
Welding of high strength steel, heavy duty structural fabrication, fine grained, Q & T steel, pressure vessels, tanks, Penstocks.

Characteristics on Usage

A basic coated low hydrogen iron powder type electrode. it is used for welding heavy section of fine grained, high strength steel. It's running very smooth and easy slag removable, yielding a weld deposit containing 1.50%Mn and 0.7%Ni. it gives radiographic quality and low temperature service down to minus 60°C.

Notes On Usage

- 1) Dry the electrodes at 350 -400°C for 60 min before use.
- 2) Keep the arc as short as possible .
- 3) 3) Adopt back step method or strike the arc on a small plate prepared for this particular purpose because ar striking o the base metal is in danger of initing cracking.

Welding Positions**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Ni %
0.090 Max	1.60 Max	0.30 Max	0.030 Max	0.030 Max	1.50 Max

Mechanical Properties Of Weld Metal

U.T.S.	Y.S.	ELONGATION	IMPACT (CVN)	Hydrogen (Mercury method)
(N/mm ²)	(N/mm ²)	(L = 4d) %	AT – 50 ° C (J)	in 100grm weld metal
520 Mn	450 Min	22 % Min	40 Joules Min	5 ml (Max)

Approvals

E.I.L

Packing and Welding Current

SIZE (mm)	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 x 350	150	600	AC / DC (+)	70 – 90
3.15 x 350	100	400		90 – 120
4.00 x 350	70	280		110 – 150
5.00 x 350	45	180		150 – 200