

**Applications**

It is used for welding of nickel alloy equipments. Fabrication of pressure vessels, piping system, valves and tanks. Used for welding low temperature service for Locomotive main frames, Refineries, Pipe lines.

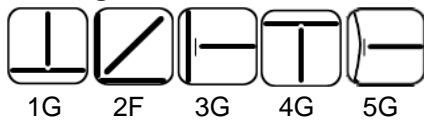
**Characteristics on Usage**

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**Notes On Usage**

- 1) Keep the arc as short as possible.
- 2) Keep the arc as short as possible.

**Welding Positions**



**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Cr %	Ni %	V %	Mo %
0.12 Max	0.40 - 1.25	0.80 Max	0.030 Max	0.030 Max	0.15 Max	0.80 - 1.10	0.05 Max.	0.35 Max

**Mechanical Properties Of Weld Metal**

U.T.S. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %	IMPACT (CVN) AT -40 °C ( J )
550 Min	470 Min	24 % Min	27 Joules Min

**Packing and Welding Current**

SIZE ( mm )	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50X350	150	600	AC/DC (+)	60-90
3.15X450	100	400		100-140
4.00X450	70	280		140-180
5.00X450	45	180		180-250