

**Applications**

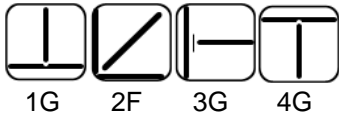
It is used for welding earth moving equipment's. Steam turbine, rotors of chemical plants. Heavy machinery parts made of high tensile steel. Automotive parts and armour steel of Ni-Cr-Mo based.

**Characteristics on Usage**

It is a hydrogen controlled medium heavy coated all position electrode. It has better creep resistance properties as well as corrosion resistance properties. It gives weld deposit which contain 1% of Cr & 2.5% of Ni. The weld metal is of radiographic quality and possess excellent strength combined with good toughness. This electrode is used for welding of high tensile, low alloy steels, which contains Ni-Cr-Mo types. Therefore, it is used in Chemical plants, especially for the welding of steam turbine, rotors etc. Redry the electrodes at 300 °C about an hour for better results

**Notes On Usage**

- 1) Dry the electrode at 350-400 °C for 60 Min- before use.
- 2) Adopt back step method or strike the arc on a small steel plate prepared for this particular purpose.
- 3) Preheat at 100 - 150 °C The temp. varies in accordance with plate thickness and kind of steel.

**Welding Positions****Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %
0.10 Max	1.00 Min	0.20 – 0.50	0.030 Max	0.030 Max	0.8 – 1.20	2.20 – 2.80	0.60– 0.90

**Mechanical Properties Of Weld Metal**

U.T.S.	Y.S.	ELONGATION	IMPACT ( CVN )
(N/mm <sup>2</sup> )	(N/mm <sup>2</sup> )	( L = 4d ) %	AT R. Temp.(27 ± 2)
690 Min	600 Min	16 % Min	50 Joules Min

**Packing and Welding Current**

SIZE ( mm )	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 x 350	150	600	AC / DC (+)	60 – 90
3.15 x 450	100	400		100– 130
4.00 x 450	70	280		140 – 180
5.00 x 450	45	180		180 – 230