

**Applications**

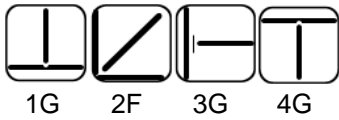
Welding of high tensile steel such as USS – T - 1. Welding of Penstocks, Earth moving equipment's. Heavy duty structural steel, fabrication for High Tensile Steel.

**Characteristics on Usage**

It is a medium heavy basic coated low hydrogen, low alloy iron powder type electrode, used for welding high tensile fully killed fine grained steel. The electrode has excellent welding characteristics and operates in all position. It gives radiographic quality of welds with easily removable slag and has good notch toughness down to minus 50 °C. It's deposition efficiency is approximately 112%, dry the electrode at 350 °C for 2 hours to obtain good results.

**Notes On Usage**

- 1) Dry the electrode at 350-450 °C for 60 Min- before use.
- 2) Preheat at 200 - 300 °C
- 3) Keep the arc as short as possible.

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

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %	V %
0.10 Max	0.75 – 1.70	0.60 Max	0.03 Max	0.03 Max	0.35 Max	1.40 – 2.10	0.25 – 0.50	0.05 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 – 50 ° C ( J )
690 Min	600 Min	16 % Min	27 Joules Min

**Approvals****Packing and Welding Current**

SIZE ( mm )	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 x 350	150	600	AC / DC (+)	80 – 100
3.15 x 450	100	400		100 – 140
4.00 x 450	70	280		140 – 180
5.00 x 450	45	180		180 - 230