

Applications

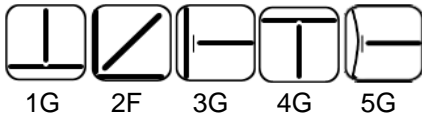
This includes general fabrication, ship building, galvanized steel, bridges, heavy equipments, rail, road, cars etc.

Characteristics on Usage

This electrodes is designed to take advantage of all position with AC or DC reverse polarity (DC +). The cellulose base coating produces deeply penetrating spray Arc. Bead is flat with thin brittle slag. Weld Metal has high tensile strength, ductility and is of X-Ray quality.

Notes On Usage

- 1) Pay Attention not to use currents exceeding the recommended currents.
- 2) As this electrode is prone to absorb moisture, store it with care.

Welding Positions**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%
0.20 Max	1.20 Max	1.00 Max	0.030 Max	0.030 Max

Mechanical Properties Of Weld Metal

U.T.S.	Y.S.	ELONGATION	IMPACT (CVN)
(N/mm ²)	(N/mm ²)	(L = 4d) %	AT - 30° C (J)
450 Min	350 Min	22 % Min	27 Joules Min

Approvals**Packing and Welding Current**

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	5	20	AC/ DC +ve	55-75
3.15 x 350	5	20		80-120
4.00 x 350	5	20		120-160
5.00 x 350	5	20		160-220