

Applications

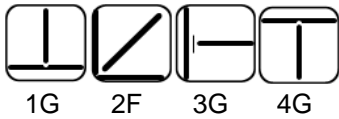
Joining of Alloy 625 alloy 825 and other similar material, dissimilar Material. Austenitic stainless steel to Ni-Cr-Mo grade steel of the 9 % Ni type for cryogenic services. Overlay welding of carbon and low Alloyed steels.

Characteristics on Usage

This type of electrode is used for welding of nickel – chromium & molybdenum Alloys Steel. For surfacing steel with nickel – chromium molybdenum weld metal. These electrodes also can be used for welding nickel base inconel 625 alloys steel where the temp. ranges from cryogenic to 9800 C for optimum resistance to pitting corrosion stress corrosion cracking in chloride containing environment.

Notes On Usage

- 1) Chip off base metal completely at the repairing part .
- 2) There is possibility that cracks spreads or makes holes at both ends of repairing part .
- 3) Keep the weld metal length less than 50 mm (2 inch) to disperse welding heat- adopt back stepping stone or symmetry method by turns.
- 4) The preheat temprature vary in accordance with te size ,king and shape of the base metal 150°C is appropriate in general .

Welding Positions**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %	Cb%
0.10 Max	1.0 Max	0.75 Max	0.02 Max	0.03 Max	20 – 23	55 Min.	8-10	3.15 -4.15
Cu %	Fe%							
0.50 Max	7.0 Max							

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION
550 Min	30 % Min

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	2	10	AC / DC (+)	80 – 100
3.15 x 350	2	10		100 – 140
4.00 x 350	2	10		140 – 180
5.00 x 350	2	10		180 – 230

Packing

Vaccum packing