

**Applications**

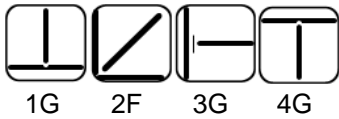
Electrodes of this classification are used for welding 9% Nickel steel base metal are ASTM A333, A334, A353, A522, and A553 etc.

**Characteristics on Usage**

This type of electrode is used for welding of 9% nickel- chromium and molybdenum Alloys Steel. For surfacing steel with nickel – chromium molybdenum weld metal deposit 65% Ni, 14.5%Cr, 7%Fe, 7%Mo, 3%Mn, 1.5%W, and 1.5%Nb plus Ta electrode having diameter 3.15 for welding in all position and 4.0, 5.0 diameters for flat horizontal position with easily slag removal and good bead finish.

**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	2.0 – 4.0	1.00 Max	0.020 Max	0.030 Max	12.0 - 17.0	55.0 Min	5.0-9.0	0.5 - 2.0

Cu %	Fe%	W%
0.50 Max	10.0 Max	1.0-2.0

**Mechanical Properties Of Weld Metal**

U.T.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %	BEND TEST
620 Min	20 % Min	Satisfactory

**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