

Applications

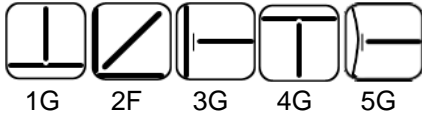
It is used for welding of nickel alloy piping, system valves and tanks. Used for welding low temperature service for Locomotive main frames, Refineries, Pipelines, Equipments, fabrication of pressure vessels.

Characteristics on Usage

A medium heavy coated low hydrogen iron powder type electrodes. the weld metal deposits 1.0 % Ni in the weld metal. It is specially designed for welding fine grained steel, nickel alloy steel. It gives high ductility , toughness and resistance to the service temperature at minus 50 °C The electrode gives smooth arc with medium penetration and negligible spatter. It is all position electrodes with Radiographic quality of weld deposit..

Notes On Usage

- 1) Dry the electrode at 250 °C for 60 Min- before use .
- 2) Keep the arc as short as possible.

Welding Positions**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Cr %	Ni %	V %	Mo %
0.08 Max	0.40 - 1.40	0.50 Max	0.030 Max	0.030 Max	0.15 Max	0.80 - 1.10	0.05 Max	0.35 Max

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	IMPACT (CVN) AT – 50 ° C (J)
490 Min	390 Min	22 Min	27 Min

Packing and Welding Current

SIZE (mm)	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50X350	150	600	AC/DC (+)	60-90
3.15X450	100	400		100-140
4.00X450	70	280		140-180
5.00X450	45	180		180-250