

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. Equipment's. fabrication of pressure vessels,

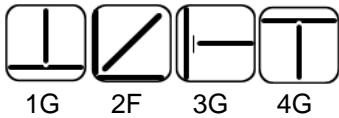
Characteristics on Usage

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. Equipment's. fabrication of pressure vessels,

Notes On Usage

- 1) Dry the electrodes at 350 - 400°C
- 2) Preheat at 80 - 100°C
- 3) Keep the arc as short as possible .

Welding Positions



Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Ni %
0.12 Max	1.25 Max	0.80 Max	0.030 Max	0.030 Max	2.0 - 2.75

Mechanical Properties Of Weld Metal

U.T.S.	Y.S.	ELONGATION	IMPACT (C.V.N.)
(N/mm ²)	(N/mm ²)	(L = 4d) %	AT - 60 °C (J)
550 Min	460 Min	20 % Min	27 Joules Min

Approvals

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