

**Applications**

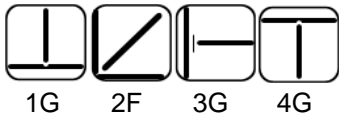
Welding of grain refined steels. Q&T steel, HSLA steel, structural fabrication, Penstocks, Tanks, pressure vessels.

**Characteristics on Usage**

A heavy coated low hydrogen iron powder type electrode. welding in all positions. Used for welding steel having high tensile strength upto 70 Kg/mm<sup>2</sup> as well as low alloy structural steel. the weld metal is of radiographic quality having excellent welding characteristics like crack resistant with good toughness down to minus 50°C.

**Notes On Usage**

- 1) Dry the electrode at 350-400 °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%	Ni %	Mo %
0.12 Max	1.0- 1.75	0.80 Max	0.030 Max	0.030 Max	0.90 Max	0.25 – 0.45

**Mechanical Properties Of Weld Metal**

U.T.S. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %	IMPACT (CVN) AT – 50 ° C ( J )
620 Min	530 Min	22 % Min	50 Joules

**Approvals****Packing and Welding Current**

SIZE ( mm )	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 x 350	150	600	AC / DC (+)	70 – 100
3.15 x 450	100	400		100 – 140
4.00 x 450	70	280		140 – 180
5.00 x 450	45	180		180 – 230