

Applications

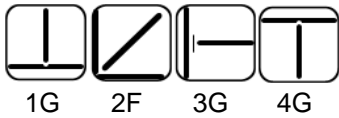
Welding of grain refined steels. Q&T steel, HSLA steel, structural fabrication, Penstocks, Tanks, pressure vessels.

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/mm² 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 electrodes at 350 - 400°C for 60 min before use.
- 2) Keep the arc as short as possible .
- 3) Adopt back step method or strike the arc on a small plate prepared for this particular purpose because ar striking o the base metal is in danger of initing cracking.

Welding Positions**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Ni %	Mo %
0.070 Max	1.70 Max	0.80 Max	0.030 Max	0.030 Max	1.40 Max	0.50

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	IMPACT (CVN) AT - 51 °C (J)
620 Min	530 Min	20 % Min	40 Joules Min

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