

**Applications**

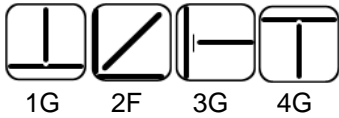
Welding of grain refined steels. Q&T steel, HSLA steel, and ASTM A615 Grade 60 steel, structural fabrication, Penstocks, Tanks, pressure vessels.

**Characteristics on Usage**

A heavy coated low hydrogen iron powder type electrodes , 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 is of radiographic like quality having excellent welding characteristics like crack resistance with good toughness down to minus 51°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%	Cr %	Ni %	Mo %
0.10 Max	0.60-1.25	0.80 Max	0.030 Max	0.030 Max	0.15 max	1.40-1.80	0.35

**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 )	HARDNESS
620 Min	540 Min	24 % Min	27 Joules Min	200 BHN Max

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

SIZE ( mm )	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50X350	150	600	AC/DC (+)	70-100
3.15X450	100	400		100-140
4.00X450	70	280		140-180
5.00X450	45	180		180-230