

Applications

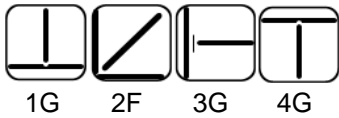
Welding of high strength steel, heavy duty structural fabrication, fine grained, Q & T steel, pressure vessels, tanks, Penstocks.

Characteristics on Usage

A basic coated low hydrogen iron powder type electrode. it is used for welding heavy section of fine grained, high strength steel. It's running very smooth and easy slag removable, yielding a weld deposit containing 1.50% Mn and 0.7%Ni. it gives radiographic quality and low temperature service down to minus 60°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 arc striking on the base metal is in danger of initiating cracking.

Welding Positions**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Cr %	Ni %	V %	Mo %	Cu %
0.10 Max	1.00 Min	0.80 Min	0.030 Max	0.030 Max	0.30 Min	0.50 Min	0.10 Min	0.20 Min	0.20 Min

Mechanical Properties Of Weld Metal

U.T.S.	Y.S.	ELONGATION	IMPACT (CVN)	Hydrogen (Mercury method)	Reduction Area %
(N/mm ²)	(N/mm ²)	(L = 4d) %	AT – 50 ° C (J)	in 100grm weld metal	
550 Min	460 Min	19 % Min	40 Joules Min	5 ml (Max)	50 - 80

Approvals

E.I.L

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 – 90
3.15 x 450	100	400		90 – 120
4.00 x 450	70	280		110 – 150
5.00 x 450	45	180		150 – 200