

Applications

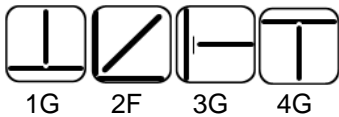
For joining Mild Steel to Cast Iron, For Butt Welding on Rail Ends & Railway Class III Steels, For fixing Rails to Mild Steel Girders for Overhead Cranes.

Characteristics on Usage

A midium heavy coated all position hydrogen controlled electrode for the welding of medum high tensile structural steel such as Carbon steel up to 0.4% C, Manganese steel up to 2.0% Mn, Silicon steel up to 0.5% Cr, Chrome Nickel steel and other heat treated steels where matching of base metal and weld metal is not necessary. Gives radiographjc quality welding.

Notes On Usage

- 1) Dry the electrode at 350-400 °C for 60 Min- before use .
- 2) Keep the arc as short as possible.
- 3) Use wind screen against strong wind

Welding Positions**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %	V %
0.15 Max	1.25 Max	0.90 Max	0.035 Max	0.035 Max	0.20 Max	0.30 Max	0.30 Max	0.08 Max

Mechanical Properties Of Weld Metal

U.T.S.	Y.S.	ELONGATION	IMPACT (CVN)	Hydrogen (Mercury method)
(N/mm ²)	(N/mm ²)	(L = 4d) %	AT - 30° C (J)	in 100grm weld metal
490 Min	400 Min	22 % Min	50 - 80 Joules	5 ml (Max)

Approvals**Packing and Welding Current**

SIZE (mm)	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 X 350	225	900	DC +ve	60-95
3.15 X 450	130	520		90-120
4.00 X 450	85	340		140-190
5.00 X 450	55	220		190-250
6.30 X 450	30	120		250-310