

Applications

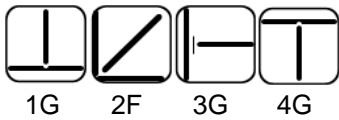
For joining Mild Steel to Cast Iron, For Butt Welding on Rail Ends & Railway Class III Steels, For fixing Rails to Mild Steel Girders for Overhead Cranes.

Characteristics on Usage

A medium heavy coated all position hydrogen controlled electrode for The welding of medium high tensile structural steel such as Carbon steels upto 0.4% C, Manganese steel upto 2.0% Mn, Silicon steel upto 0.5% Cr, Chrome Nickel steels and other heat treated steels where matching of base metal and weld metal is not necessary. Gives radiographic quality welding & deposition efficiency of 112% approximately.

Notes On Usage

- 1) Dry the electrode at 300-350 °C for 60 min.before use.
- 2) Adopt back step method or strike the arc on a small steel plate prepared for this particular pupose to prevent blow hole at the arc starting.
- 3) Keep the arc as short as possible.

Welding Positions**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %	V %
0.15 Max	1.60 Max	0.75 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 = 5d)	AT - 30° C (J)	in 100grm weld metal
490 Min	400 Min	22 Min	27 Joules Min	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	AC (OCV 70) / DC (+)	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