

Applications

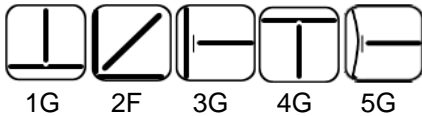
Used in joining of cross country steel pipelines. Pressure Pipelines, Storage Tanks. Structural fabrication. Field works where deep penetration is required.

Characteristics on Usage

It is a medium coated all position cellulosic electrode, provides a deep penetration forceful arc with readily removable thin friable slag and deposits a flat bead with high melting rate. It can be used in all position particularly on multi pass welding in vertical and overhead positions, gives 100% radiographic quality of welds.

Notes On Usage

- 1) Pay Attention not to use currents exceeding the recommended currents.
- 2) As this electrode is prone to absorb moisture, store it with care.

Welding Positions**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%
0.20 Max	1.20 Max	1.00 Max	0.03 Max	0.03 Max

Mechanical Properties Of Weld Metal

U.T.S.	Y.S.	ELONGATION	IMPACT (CVN)
(N/mm ²)	(N/mm ²)	(L = 4d) %	AT - 30° C (J)
450 Min	370 Min	22.0 % Min	27 Joules Min

Approvals

E.I.L. ,IOCL ,KNPC

Packing and Welding Current

SIZE (mm)	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 x 350	210	840	DC (+)	60 – 90
3.15 x 350	125	500		80 – 140
4.00 x 350	80	320		120 – 180
5.00 x 350	50	200		180 – 240