

Applications

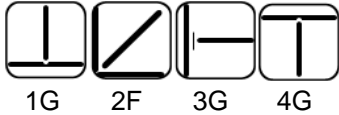
Bridges & Boilers, Compressors, Automobile Parts & Fine Steel Furniture, Railway Coaches, Locomotive Fireboxes, Scooter Frames.

Characteristics on Usage

A heavy coated all position electrode for major or minor structural work. The weld metal is radiographic quality, smooth arc, low spatter and medium penetration.

Notes On Usage

- 1) In case of varticle download welding,manipulate the electrode,keeping its tip in contact with base metal.
- 2) Dry the electrode at 70-100 °C for 30-60 min.before use.

Welding Positions**Chemical Composition Of Weld Metal**

| C% | Mn% | Si% | S% | P% |
|----------|----------|---------|-----------|-----------|
| 0.12 Max | 0.75 Max | 0.50Max | 0.030 Max | 0.030 Max |

Mechanical Properties Of Weld Metal

| U.T.S. | Y.S. | ELONGATION | IMPACT (CVN) | RADIOGRPHY TEST |
|----------------------|----------------------|------------|-------------------|--------------------|
| (N/mm ²) | (N/mm ²) | (L = 5d) | AT 0° C | |
| 400 - 560 Min | 330 Min | 22 % Min | 47 Joules Min | Satisfactory |

Approvals

P.D.I.L., B.V.,IOCL

Packing and Welding Current

| SIZE (mm) | PIECES PER PACKET | PIECES PER CARTON | Current (Amps) | In Amps |
|-------------|----------------------|----------------------|----------------|-----------|
| 2.50 x 350 | 175 | 700 | AC / DC (-) | 60 – 90 |
| 3.15 x 450 | 105 | 420 | | 100 – 140 |
| 4.00 x 450 | 65 | 260 | | 140 – 190 |
| 5.00 x 450 | 40 | 160 | | 190 – 250 |