

**Applications**

Suitable for Surfacing and welding of Straight Chrom Steel. Such as AISI 430 Grade. Automobile body moulding, Oil burner parts, equipments in the chemical & food industries.

**Characteristics on Usage**

It is a heavy coated basic type all position electrode depositing 17% Chrom type of weld metal. The weld metal has good resistance to corrosion, heat and is of radiographic quality.

**Notes On Usage**

- 1) Preheat the job at 150-200°C & PWHT. at 760 - 790°C for one hour soaking
- 2) Remove rust, water, oil, paint etc. from groove
- 3) keep the current as low as possible
- 4) Dry the electrodes at 350°C for 60 minute before use

**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %
0.10 Max	1.00 Max	0.90 Max	0.030 Max	0.040 Max	15 – 18.00	0.60 Max	0.75 Max

**Mechanical Properties Of Weld Metal**

U.T.S. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %
540	470	20

**Packing and Welding Current**

SIZE ( mm )	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	2	10	DC (+)	60 – 90
3.15 x 350	2	10		90 - 130
4.00 x 350	2	10		130 - 160
5.00 x 350	2	10		170 - 200

**Packing**

Vacuum packing