

Applications

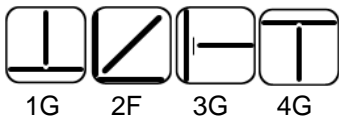
Suitable for joining ferritic to austenitic steels, Armour plates. Heat resistant steels, dissimilar materials. Buffers layers on difficult steels before hardfacing. Excellent for repairing cracks in austenitic manganese steel, castings for surfacing manganese steel.

Characteristics on Usage

It is a light-basic coated multi purpose stainless steel electrode with S.S. corewire, easy to operate in all position at low current. The weld metal has excellent crack resistance as well as hear resistance at 900° C. It is also corrosion resistant to atmosphere, marine water and weak acids. It gives 18% Cr, 8% Ni & 5% Mn type weld deposit, easily removable slag. It is to be dried at 250° C for 1 hour before welding.

Notes On Usage

- 1) Keep the arc as short as possible.
- 2) Remove dirt such as oil and dust from the groove.
- 3) Dry the electrode at 350°C for 60 Min. before use.

Welding Positions**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %
0.20 Max	5.0 - 8.0	0.90 Max	0.030 Max	0.040 Max	17.0 - 20.0	7.0 - 10.0	0.50 Max

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION (L = 5d)
560 - 670	30 - 40

Approvals

RDSO IRSM - 28/86 Class M5

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	2	10	DC (+) / 70 OCV	50 - 75
3.15 x 350	2	10		80 - 110
4.00 x 350	2	10		110 - 150
5.00 x 350	2	10		150 - 200

Packing

Vaccum packing