

Applications

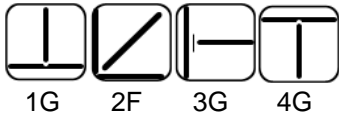
It is used for welding of duplex stainless steel material where the weld metal deposited combines increase tensile strength with improve resistance to pitting corrosive.

Characteristics on Usage

The normal composition (wt. %) of this weld metal is contain 22.2 %Cr, 9.5 % Ni & 0.15% N. Electrodes of this composition are used primarily to weld duplex stainless steels which contain approximately 22 percent of chromium.

Notes On Usage

- 1) Dry the electrodes at 350°C for 60 minute before use
- 2) keep the current as low as possible
- 3) Remove rust, water, oil, paint etc. from groove

Welding Positions**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %	Cu %	N%
0.040Max	0.50– 2.00	1.00 Max	0.030 Max	0.040 Max	22.5 – 23.5	8.5 – 10.5	2.5-3.50	0.75Max	0.08- 0.20

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
690	20-28

Approvals

IOCL

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	2	10	AC / DC + Ve	50 – 90
3.15 x 350	2	10		90 – 140
4.00 x 350	2	10		120 – 170
5.00 x 350	2	10		180 – 220

Packing

Vaccum packing