

**Applications**

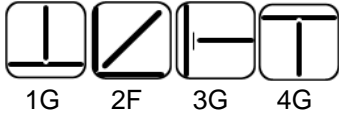
Suitable for welding of Heavy machinery parts, earth moving equipments, automobile spring, trunnions of cement mill and other allied components, parts subject to corrosion and impact. Joining and surfacing of High Carbon, low and high alloy steel, tool steel, spring steel, manganese steel, case hardening steel, high speed steel, cast steel etc

**Characteristics on Usage**

A medium heavy coated rutile type all position electrode giving 30 % Cr. And 10 % Nickel weld deposit. The electrode has very soft arc and gives smooth and defect free austeno ferrite weld metal. Almost no distortion and embrittlement of the base material. The weld metal is resistant to friction, heat and corrosion is work hardening and shockproof gives radiography weld deposit.

**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**

1G 2F 3G 4G

**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %
0.15 Max	0.50 – 2.50	1.00Max	0.030 Max	0.040 Max	28.0 - 32.0	8.0 – 10.50	0.75 Max

**Mechanical Properties Of Weld Metal**

U.T.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %
660	22

**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 – 70
3.15 x 350	2	10		70 – 100
4.00 x 350	2	10		100 – 130
5.00 x 350	2	10		130 – 160

**Packing**

Vaccum packing