

Applications

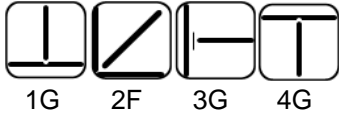
Turbines, armature valves & pumps.

Characteristics on Usage

This electrode is used for welding and surfacing of 13% chromium steel. It is also recommended for using in turbines, armature valves and pumps. The weld metal is of radiographic quality, resistant to friction, corrosion and oxidation.

Notes On Usage

- 1) Preheat the job at 150-200°C & PWHT. at 730 - 760°C for one hour soaking
- 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 %
0.12 Max	1.00 Max	0.90 Max	0.03 Max	0.04 Max	11.0 - 13.5	0.70 Max	0.75 Max

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %
520 Min	470 Min	20% Min

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	2	10	DC (+)	60 - 80
3.15 x 350	2	10		80 - 100
4.00 x 350	2	10		100 - 140
5.00 x 350	2	10		140 - 180

Packing

Vacuum packing