

Applications

Suitable for welding steel containing 22 – 26% and 11 - 14 % Ni, 2 - 3 % Mo also for joints between 18 Cr - 8 Ni stainless steel and mild steel or low alloy steel.

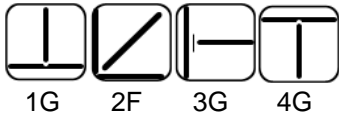
Characteristics on Usage

Use in all positions. Suitable for shield metal arc welding (SMAW) in all positions. Recommended for use with AC or DC (+) power source. Electrode should be stored in a dry container. Preheat is not required. Interpass temperature should be maintained below 300°C. Post weld heat treatment is not required.

Notes On Usage

- 1) Dry the electrode at 350°C for 60 Min- before use.
- 2) Keep the arc as short as possible.
- 3) Use currents as low as possible to avoid excessive dilution.

Welding Positions



Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %
0.12 Max	0.50 – 2.50	1.00 Max	0.030 Max	0.040 Max	22.0 - 25.0	12.0 - 14.0	2.0 - 3.0

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
550	30 % Min

Approvals

K.P.G.I.L

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	2	10	AC / DC (+)	45 – 85
3.15 x 350	2	10		85 - 115
4.00 x 350	2	10		100 - 145
5.00 x 350	2	10		135 – 180

Packing

Vaccum packing