

MOISTURE RESISTANCE ELECTRODE FOR WELDING LOW ALLOY AND HIGH TENSILE STRENGTH STEELS.

Alloy Basis

C, Mn, Si

Characteristics :

Low Hydrogen Electrodes with non-hygrosopic coating, high arc force purges out impurities and hence suitable for welding cast steel with high sulphur. The weld bead has good appearance and slag peels off easily. The weld metal is tough, extremely ductile, resistant to cracking and of radiographic quality.

Typical Applications

Used for joining and building up of low and medium carbon steels. Ideal for joining dissimilar sections, restrained joints and oil soaked parts, castings. Welding of crane zibs, frames, truck chases, heavy equipment maintenance etc.

Mechanical Properties

Tensile Strength : 500 – 570 MPa

Elongation Min : 22 %

Welding Current : AC, DCEP

Size (Ø mm)	2.50	3.15	4.00	5.00
Current (amps)	60 - 90	100 - 130	140 - 180	180 - 220

Availability:

Standard Size: 5.0, 4.0, 3.15, 2.5 in 350 mm length

Packing: 2 kg.

Procedure

Clean the area to be welded. Adopt a short arc on a DC power source with reverse polarity. vertical joints should be welded from the bottom up by weaving rapidly.

