

## ELECTRODE FOR HIGH STRENGTH JOINING OF LOW AND MEDIUM CARBON AND LOW ALLOY STEELS.

### Alloy Basis

Fe, Ni, Cr,

### Characteristics :

All position low heat input electrodes with high ductility, excellence crack resistance.

### Typical Applications

Joining stainless steel to low alloy steels, carbon steels, surfacing on mild steel to improve wear resistance. Used for cladding purposes on carbon steel. also used for the rapport of buckets, boom C frames and undercarriage components of earthmoving equipment..

### Mechanical Properties

Tensile Strength : 520 – 620 MPa  
Elongation Min : 30 %

### Welding Current : AC, DCEP

Size (Ø mm)	2.50	3.15	4.00	5.00
Current (amps)	50 - 80	90 - 110	120 - 140	150 - 190

### 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. For heavy thickness prepare a 90° U groove. Fit up should be accurate for long joints. Weld at regular intervals and use jigs & fixtures to avoid distortion. Use DC+ on DC Power source for good ripple and finish. Stringer bead technique with the shortest possible arc length is recommended. when welding manganese steel do not allow the job temperature to exceed 150 °C.

