

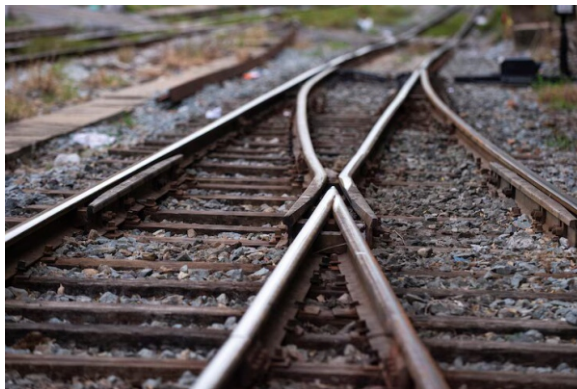
ELECTRODE WITH EXCELLENCE RESISTANCE TO IMPACT WITH WORK HARDENING CAPABILITIES.

Alloy Basis

Cr, Mn

Characteristics :

The deposited weld metal shows stable austenitic structure having scattered carbides. The weld metal has high tensile strength, toughness and wear resistance.



Typical Application

For welding of 13% Mn steel, For Rail crossing. For welding bullet proof armor quality steel plate. For welding hard or unidentified steels. For heavy, crack free build-ups. The electrode can be used for dissimilar joints consisting of high manganese and other steels.

Mechanical Properties

Hardness

As welded : 14 – 18 HRC

Work Hardened : 42 – 55 HRC

Welding Current : AC, DCEP

Size (Ø mm)	3.15	4.00	5.00
Current (amps)	90 - 120	120 - 160	160 - 200

Availability:

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

Packing: 2 kg.

Note to Usage

Clean the weld metal surface, Hold medium/short arc and adopt staggered technique to avoid overheating. Slow cool to room temperature. Silicon carbide wheel is recommended for grinding.