

**Applications**

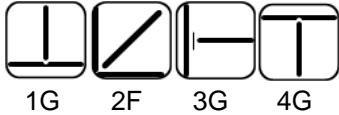
It is used for welding of duplex stainless steel material where the weld metal deposited combines increase tensile strength with improve resistance to pitting corrosive.

**Characteristics on Usage**

The normal composition (wt. %) of this weld metal is contain 22.2 %Cr, 9.5 % Ni & 0.15% N. Electrodes of this composition are used primarily to weld duplex stainless steels which contain approximately 22% of chromium.

**Notes On Usage**

- 1) Dry the electrodes at 350° C for 60 min. before use.
- 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 %	Cu %	N%
0.040Max	0.50– 2.00	1.00 Max	0.030 Max	0.040 Max	22.5 – 23.5	8.5 – 10.5	2.5-3.50	0.75Max	0.08- 0.20

**Mechanical Properties Of Weld Metal**

U.T.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %
690	20-28

**Packing and Welding Current**

SIZE ( mm )	KG PER PACKET	KG PER CARTON	LBS PER PACKET	LBS PER CARTON	In Amps	Current (Amps)
2.50 X 350	2	10	4.40	22.05	50 – 90	AC / DC + Ve
3.20 X 350	2	10	4.40	22.05	90 – 140	
4.00 X 350	2	10	4.40	22.05	120 – 170	
5.00 X 350	2	10	4.40	22.05	180 – 220	

**Packing**

Vaccum pack