

Applications

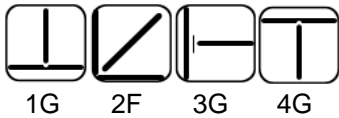
It is used for welding of duplex stainless steel such as SAF 2507, Zeron 100, ferralium 255 , UR47N , DP3 etc.

Characteristics on Usage

It is rutile base electrode specially designed for welding of Super duplex stainless steels. Which contain 25%Cr, 8 % Ni & 3% Mo. The deposited weld metal has a duplex microstructure consisting of an austenite ferrite matrix, with high ductility and improved resistance to pitting corrosive attack and to stress corrosion cracking. It gives excellent welding characteristic in all position with smooth and stable arc, self lifting slag .The weld bead is smooth, fine rippled and shiny.

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 %	N%	Cu %
0.060Max	0.50- 1.50	1.00 Max	0.030 Max	0.040 Max	24.0 - 27.0	6.5 – 8.5	2.9-3.90	0.10- 0.25	1.50-2.50

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
760	15.0

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	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