

Applications

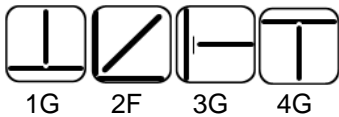
These electrodes are used primarily for welding of type 904 L material for the handling of sulphuric acid and many chloride contain media. It is also used for HV – 9 A and HV-9 stainless steel and similar alloy for high temperature services in the jet aircraft industry

Characteristics on Usage

It is semi basic coated all position electrode giving a smooth arc, medium penetration & weld deposit of 20 % Cr, 25% Ni, 5 % Mo & 1.5 % Cu. Which possesses excellent corrosion and heat resistance up to 1200° C. Frequently encountered in fully austenitic weld metal leaving smooth bead having fine ripples with self lifting slag.

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 %
0.03 Max	1.0 - 2.5	0.90 Max	0.020 Max	0.030 Max	19.5 - 21.5	24.0 - 26.0	4.20 – 5.20	1.2 – 2.0

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
550	30

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 – 70	AC / DC (+)
3.20 X 350	2	10	4.40	22.05	80-100	
4.00 X 350	2	10	4.40	22.05	100-140	
5.00 X 350	2	10	4.40	22.05	140-180	

Packing

Vaccum pack