

**Applications**

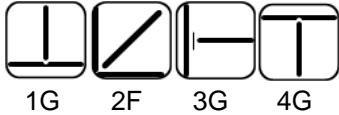
Used for Bridges & Boilers, Compressors, Automobile parts, Fine steel furnitures, Railway coaches, Locomotive fireboxes & Scooter frames.

**Characteristics on Usage**

A heavy coated all position electrode for major or minor structural work. The weld metal is radiographic quality, smooth arc, low spatter and medium penetration.

**Notes On Usage**

- 1) In case of varticle download welding manipulate the electrode keeping its tip in contact with base metal.
- 2) Dry the electrode at 70-100 °C for 30-60 min. before use.

**Welding Positions****Chemical Composition Of Weld Metal**

| C%       | Mn%      | Si%     | S%        | P%        |
|----------|----------|---------|-----------|-----------|
| 0.12 Max | 0.75 Max | 0.50Max | 0.030 Max | 0.030 Max |

**Mechanical Properties Of Weld Metal**

| U.T.S.               | Y.S.                 | ELONGATION | IMPACT<br>( CVN ) | RADIOGRPHY<br>TEST |
|----------------------|----------------------|------------|-------------------|--------------------|
| (N/mm <sup>2</sup> ) | (N/mm <sup>2</sup> ) | ( L = 5d ) | AT 0° C           |                    |
| 400 - 560 Min        | 330 Min              | 22 % Min   | 47 Joules Min     | Satisfactory       |

**Approvals**

B.V.

**Packing and Welding Current**

| SIZE ( mm )    | KG PER<br>PACKET | KG PER<br>CARTON | LBS PER<br>PACKET | LBS PER<br>CARTON | In Amps   | Current (Amps) |
|----------------|------------------|------------------|-------------------|-------------------|-----------|----------------|
| 2.50 X 350     | 5                | 20               | 11                | 44                | 60 – 90   | AC / DC (-)    |
| 3.20 X 350/450 | 5                | 20               | 11                | 44                | 100 – 140 |                |
| 4.00 X 350/450 | 5                | 20               | 11                | 44                | 140 – 190 |                |
| 5.00 X 350/450 | 5                | 20               | 11                | 44                | 190 – 250 |                |