

Applications

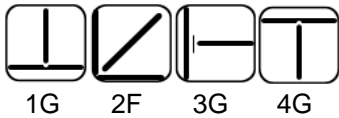
It is used for welding of duplex stainless steel material where the weld metal deposited combines increase tensile strength with improve resistance to pitting corrosive.

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 ²)	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