

**Applications**

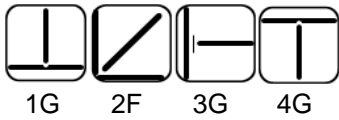
It is used for welding of AISI 317L type SS plates as well as 316L similar type of material. For joining of stainless steel to low alloy and carbon steel .for serve corrosion applications involving sulphuric acid and their salts.

**Characteristics on Usage**

A medium stainless steel electrode depositing an extra low carbon weld metal containing 19 Cr, 12 Ni, and 3 Mo. The weld metal is resistance to inter crystalline corrosion, stress corrosion cracking, hot cracking and chemical corrosion against sulphuric acid, phosphoric acid etc. The higher molybdenum content reduces the susceptibility to pitting; improve creep strength at elevated temp and practically eliminates cracking as the weld cools from molten stage to room temp. Redry electrodes at 300° C one hour for better results.

**Notes On Usage**

- 1) Keep the current as low as possible.
- 2) Dry the electrodes at 350° C for 60 min. before use.
- 3) Remove foreign substance such as oil, grease, dust or scale from the groove.

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

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %	Cu %
0.040 Max	0.50 – 2.50	1.00Max	0.030 Max	0.040 Max	18.0 - 21.0	12.0 – 14.0	3.0 – 4.0	0.75 Max

**Mechanical Properties Of Weld Metal**

U.T.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %
520	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 – 80	AC /DC + Ve
3.20 X 350	2	10	4.40	22.05	80 – 110	
4.00 X 350	2	10	4.40	22.05	110 – 140	
5.00 X 350	2	10	4.40	22.05	140 – 180	

**Packing**

Vaccum pack