

Applications

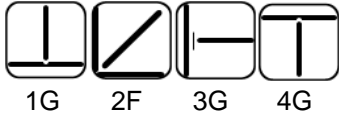
Used for Bridges & Boilers, Compressors, Automobile parts, Fine steel furnitures, Railway coaches, Locomotive fireboxes & Scooter frames.

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 (CVN)	RADIOGRPHY TEST
(N/mm ²)	(N/mm ²)	(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 PACKET	KG PER CARTON	LBS PER PACKET	LBS PER 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	