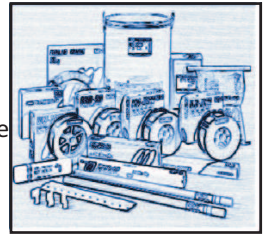


Stainless Steel Electrodes

Application :

Suitable for welding of AISI 310 type of stainless steel plates. German steel, clad steel, straight chrome steel and dissimilar steel. Gas turbine combustion chamber parts, High temperature furnace parts, Annealing boxes etc.



Characteristics on Usage :

A medium heavy basic coated type all position stainless steel electrode with excellent welding characteristics. This unique electrode is manufactured by using 25 Cr, 20 Ni, type of core wire to give 25/20/5 Mn weld deposit. The weld metal has excellent resistance to oxidation scaling up to 1200°C in continuous service. The weld metal is fully austenitic and is of radiographic quality, the electrode is be kept dry at 300 °C for 1 hour before welding.

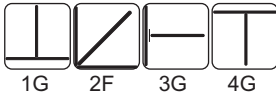
Chemical composition of All-Weld metal (%) as per AWS

C	Mn	Si	S	P	Cr	Ni
0.08-0.20	1.0-2.50	0.75 Max	0.030Max	0.030 Max	25.0-28.0	20.0-22.50

Mechanical properties of all-weld metal as per AWS

UTS (N/mm ²)	Elongation (L=4d) %
550 Min	30 % Min

Welding Positions



Packaging & Welding Current

SIZE (mm)	KG Per Packet	KG Per Carton	Current (Amps)	In Amps
2.50 x 350	2	12	AC/ DC (+)	50-75
3.15 x 350	2	12		80-120
4.00 x 350	2	12		110-140
5.00 x 350	2	12		150-180

