

Shielded Metal Arc Welding

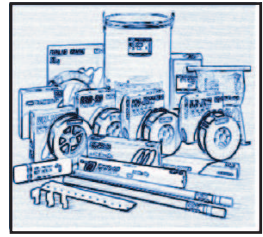
ANU BOND - 2553 (E 2553 - 16)

AWS / SFA 5.4, E 2553 - 16

Stainless Steel Electrodes

Application :

It is used for welding of duplex stainless steel as SFA 2507, Zeron 100, Inconel 255, UR47N, DP3 etc.



Characteristics on Usage :

It is rutile base electrode specially designed for welding of Super duplex stainless steels. Which contain 25% Cr, 8% Ni, and 3% Mo. The deposited weld metal has a duplex microstructure consisting of an austenite ferrite matrix, with high ductility and improved resistance to pitting corrosive attack and to stress corrosion cracking. It gives excellent welding characteristic in all position with smooth and stable arc, self lifting slag. The weld bead is smooth, fine rippled and shiny.

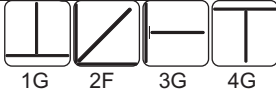
Chemical composition of All-Weld metal (%) as per AWS

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	N
0.060 Max	0.50-1.5	1.0 Max	0.030 Max	0.040 Max	24.0-27.0	6.5-8.5	2.9-3.90	1.50-2.50	0.10-0.25

Mechanical properties of all-weld metal as per AWS

UT.S (N/mm ²)	Elongation (L=4d) %
760	15

Welding Positions



Packaging & Welding Current

SIZE (mm)	KG Per Packet	KG Per Carton	Current (Amps)	In Amps
2.50 x 350	2	12	DC + Ve	50-90
3.15 x 350	2	12		90-140
4.00 x 350	2	12		120-170
5.00 x 350	2	12		180-220

