

## Shielded Metal Arc Welding

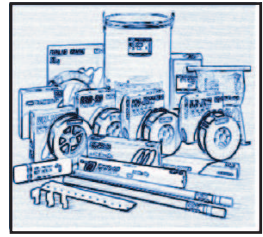
# ANU BOND - 385 (E 385- 16)

AWS :SFA 5.4,E 385 - 16

Stainless Steel Electrodes

### **Application :**

These electrode used primarily for welding of type 904 L material for the handling of sulphuric acid and many chloride contain media. It is also used for HV -9 stainless steel and similar alloy for high temperatures services in the jet aircraft industry.



### **Characteristics on Usage :**

It semi basic coated all position electrode giving a smooth arc, medium penetration and weld deposit of 20% Cr, 25% Ni, 5%Mo, and 1.5% Cu. Which possesses excellent corrosion and heat resistance up to 1200 °C. Frequently encountered in fully austenitic weld metal leaving smooth bead having fine ripples with self lifting slag.

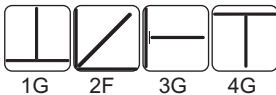
### **Chemical composition of All-Weld metal (%) as per AWS**

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
0.03 Max	1.0-2.50	0.90 Max	0.020 Max	0.030 Max	19.5-21.5	24.0-26.0	4.20-5.20	1.2-2.0

### **Mechanical properties of all-weld metal as per AWS**

UT.S (N/mm <sup>2</sup> )	Elongation ( L=4d ) %
550	30

### **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 (+)	50-70
3.15 x 350	2	12		80-100
4.00 x 350	2	12		100-140
5.00 x 350	2	12		140-180

