

TENSILE WELD

Typical applications

Welding of 29%Cr-9%Ni type cast steels and difficult-to-weld steels.
Joint welding and hardfacing of stainless steel and heat-resisting steels.

Coating

Lime titania type

Characteristics on Usage

- ① Good usability and weldability
- ② Good crack resistance because of extremely much quantity of ferrite of the deposited weld metal.
- ③ Redry the electrode at 300~350°C for 30~60 minutes prior to use.

Typical chemical composition of all-weld-metal (%)

| C | Si | Mn | Cr | Ni |
|------|------|------|------|-----|
| 0.08 | 0.95 | 1.48 | 28.9 | 8.6 |

Typical mechanical properties of all-weld-metal

| T · S N/mm ² {kgf/mm ² } | EI (%) |
|---|-----------|
| 770 {79} | 24 |

Sizes available and recommended currents (AC or DC ⊕)

| Dia. | (mm) | 2.6 | 3.2 | 4.0 | 5.0 |
|--------|------|-------|--------|---------|---------|
| Length | (mm) | 300 | 350 | 350 | 350 |
| Amp. | F | 40~80 | 70~110 | 110~140 | 140~180 |
| | V&OH | 35~70 | 70~100 | 90~130 | — |

Welding positions



Approved by