

## APPLICATION :-

Welding of AISI 309 stainless steels. It is also suitable for Joining of dissimilar materials such as 18%Cr - 8%Ni Stainless Steel to mild steel. Build up mild steel to improve wear resistance for worn out parts.

## CHARACTERISTICS ON USAGE :-

A medium-heavy coated Rutile-type all-position electrodes giving corrosion resistant 22%Cr – 12%Ni weld metal contains extra low carbon to Corrosion and oxidation resistance. Gives a quiet and stable arc, low spatter, smooth weld bead and easily detachable slag. Weld are radiographically sound.

## NOTES ON USAGE :-

Short and intermittent welding is to be preferred to avoid overheating and distortion.

### # Typical Mechanical Properties of weld metal

Ultimate Tensile Strength MPa	Yield Stress MPa	Elongation (%) (L = 4D)
560 Min	405-490	43

Redrying : - 250° C / 2 hrs.

### # Typical Chemical Composition of weld metal

C	Mn	SI	Cr	Ni	S	P	Mo	Cu	Fe
0.03 max	0.50 to 2.50 max	0.60 max	22 to 25 max	12 to 14 max	0.008 max	0.018 max	0.75 max	0.75 max	10%

### # Welding Currents

2.50mm	3.15mm	4mm	5mm
50-75	80-100	110-140	150-180

### # Packing

WIRE	CONTAINT
2.50 X 350 M.M.	2 Kg. x 5 Pkt. = 10
3.15 X 350 M.M.	2 Kg. x 5 Pkt. = 10
4.00 X 350 M.M.	2 Kg. x 5 Pkt. = 10
5.00 X 350 M.M.	2 Kg. x 5 Pkt. = 10