

## APPLICATION :-

For joining heat resistance steel and also joining unalloyed, low/high alloy & cast steels. Furnace fabrication, Steam boilers, Piping & fittings, Gas turbines, Oil refineries etc.

## CHARACTERISTICS ON USAGE :-

A medium-heavy coated , rutile-type all position electrode made from 25Cr/ 20Ni Core wire to give 25/20 weld deposit which has excellent stability and oxidation, resistance in continuous service upto 1000 C. The deposit is highly resistance to cracking.

## 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)	Impact Value	
			Temp	Joules
560 Min	380 - 480	30 - 40	-196° C	30 - 40

Redrying : - 250° C Temperature for 2 hours before use.

### # Typical Chemical Composition of weld metal

C	Mn	SI	S	P	Cr	Ni	Fe
0.12 max	1.00 to 2.50	0.60 max	0.03 max	0.03 max	22.00 to 28.00	20.00 to 22.50	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