

## APPLICATION :-

Suitable for welding stainless steels extra low carbon such as AISI grades 316L, 317L and 318, S.S. chemical plants, power plant , textile industry & food & pharmaceutical industry.

## CHARACTERISTICS ON USAGE :-

A medium heavy coated, rutile type stainless steel electrode depositing low carbon 18/13/2.5 Mo austentic stainless steel weld metal. Deposited weld metal has very high resistant to hot cracking, chemical corrosion upto 800°C and stress corrosion cracking. Molybdenum imparts resistance to corrosion of reducing nature. The deposited weld metal is of radiographic quality.

## 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
490 Min	400 - 500	30 - 40	27° C	70 - 120

Redrying : - 250° C / 2hrs.

### # 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	0.70 max	17.0 - 20.0 max	11.0 to 14.0 max	0.03 max	0.04 max	2.0 - 3.0	0.50 max	5%

### # 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