



Kiln Shell Joining

## High strength electrode for joining and repair of cast steels and HSLA steels

### Typical Applications:

Hammer bases, columns, rams, sow blocks, keyways, kiln shell.

### Outstanding Features:

- Non-hygroscopic flux coating.
- Strong, stable arc.
- Self releasing slag.
- No temper embrittlement of weld deposit has very high creep resistance property.

### Recommendation:

Joining, build-up and repair of new, worn-out or cracked steel structures, machinery components and other heavy duty equipment & welding of cast steels, fabrication of micro-alloyed and H.S.L.A. steels including automotive applications. Specially suited for repair of forging equipment like columns, sow blocks etc.

### Procedure:

Clean weld area. Remove fatigued or cracked metal. Bevel all edges 60°. For heavy sections, pre-heat 250° - 300° C. Weld with short arc gap and electrode tilted 10° in travel direction. Use 'stringer bead' deposition, chip slag between passes and peen weld beads. After completion, retard cooling by covering with sand, asbestos etc. For large assemblies and for forging equipment, stress relieving at 550°C-600°C for one hour per inch job thickness recommended.

### Recommended Amperages:

Size (mm)	Amperage
3.15	90 - 130
4.00	120 - 160
5.00	150 - 190

**Tensile Strength:** 67 Kg/mm<sup>2</sup>  
(96,000 psi)