

A Low Heat Input High Performance Stainless Steel Electrode Depositing an Extra Low Carbon 19Cr13Ni & 3Mo Weld Metal

Description:

A Flux Coated Electrode using fully alloyed core wire & having a smooth forceful and fully controllable arc with spray type metal transfer. Completely free from overheating, operates with minimal spatter and displays self-releasing slag even in fillets and Vee-grooves. The weld beads are dense, finely rippled and require minimal finishing.

Typical Applications:

For joining and cladding applications on 19-13 type of stainless steel with a maximum resistance to stress, corrosion, cracking, hot cracking and chemical corrosion at high temperature. The weld metal has excellent creep resistance and is of radiographic quality.

Unique Features:

- Conforms to AWS:SFA 5.4 E 317L-16

Technical Properties:

Typical All-weld Chemistry (Wt %):

C	Mn	Si	Cr	Ni	Mo	S	P
0.025	0.7	0.18	19.0	13.80	3.80	0.005	0.02

Typical Mechanical Properties:

Tensile Strength : 61 Kg/mm²

Elongation (L=4D) : 36%

Other Properties:

Ferrite Content : 4 – 9 %

Welding Procedure:

Clean & degrease the weld area. Bevel heavy sections 60 Deg Vee. Ensure good and uniform fit-up. Maintaining short arc, deposit stringer beads. Use staggered deposition for uniform heat input. Remove slag between passes, using stainless steel wire brush.

Welding Parameters:

Size (mm)	2.50	3.2	4.0
Amps	50 - 80	70 - 110	90 - 150

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