



Duct

Excellent contact type electrode for welding low carbon steel plates, forms and thin sheets.

Typical Applications:

Containers, ducts, tanks, bus bodies, air conditioning units, machine guards, pipe lines.

Outstanding Features:

- All position, contact type welding.
- Easy strike/re-strike.
- Low heat input, minimum distortion and warpage.
- Superior weld bead quality.

Recommendation:

Recommended for the welding of thin sheets, forms and plates, where distortion, warpage and residual stresses are to be minimised and burn through areas eliminated. A universal all position welding electrode for all types low carbon steel, producing quality weld deposits with rapid deposition and silent arc.

Procedure:

Clean joint area. Tack weld sections to maintain alignment. Hold electrode at 20° inclined in the direction of travel. Do not weave on contact welding. Arc gap to be kept minimum especially distortion & positional welding are important factors. Self-releasing slag. Deposits have very fine ripples.

Recommended Amperages:

Size (mm)	Amperage
2.50	50 - 90
3.15	90 - 140
4.00	120 - 170
5.00	140 - 200

Tensile Strength: 53 Kg/mm²
(75,000 psi)