



Plug Screw Feeder

Ideal electrode with molybdenum having excellent corrosion resistance property for both joining and overlaying.

Typical Applications:

Chemical tanks, pumps, mixers, hydraulic and steam turbine blades, plating tanks.

Outstanding Features:

- Moly-bearing stainless steel electrode.
- Resists acid pitting.
- Smooth, rapid deposition.
- Lowest amperage minimizes warpage.

Recommendation:

Excellent weldability, with smooth rapid deposition. For corrosion resistant welds on 18/8 Moly stainless steel, specifically 316/316L type. Also suitable for types 315, 318 and 329. Molybdenum and extra low carbon contents prevent acid pitting. Protective overlay on steel for high corrosion resistance and frictional resistance. Extra protection when welding highly restrained joints or crack-sensitive alloys. Superior slag control while welding in tight fit ups.

Procedure:

Clean weld area. Thickness upto 10 mm can be square butt welded. Bevel heavier thickness to 60° vee. For long seams, fit-ups should be accurate. Use suitable clamping or holding devices to minimise warping. Tack at short intervals. Deposit stringer beads maintaining short arc length. Avoid weaving. Use skip or step-back technique. Remove slag between passes. Use electrode positive with DC machine. Minimum open circuit voltage for ac: 55V.

Recommended Amperages:

Size (mm)	Amperage
2.50	40 - 70
3.15	70 - 100
4.00	90 - 140

Tensile Strength: 62 Kg/mm²
(87,000 psi)