



Coal Burner Nozzle

**Ideal electrode for joining and over laying applications of wide range stainless steel and mild steel base material with superior oxidation and heat resistance property.**

#### **Typical Applications:**

Valves, tanks, heat exchangers, heat treating boxes and baskets.

#### **Outstanding Features:**

- Ideal for oxidation and heat resistance.
- Ideal for joining of stainless steel of unknown composition.
- Smooth, rapid, spatter-free deposition.

#### **Recommendation:**

Excellent weldability, no spatter, high strength and elongation for 25/20 type stainless steel and other unknown stainless steels. Designed for applications requiring a high degree of oxidation resistance and high strength at temperatures up to 1000°C. Used also for welding stainless steel to mild steel.

#### **Procedure:**

Clean weld area. Tack at short intervals when jigs are not available. Square butt weld thickness upto 10mm. Heavier sections should be bevelled to 60°. Maintain short arc and deposit stringer beads. Avoid weaving. Deposit a number of light beads. Use an intermittent welding sequence to prevent overheating. Remove slag. Use electrode positive with DC machine. Minimum open circuit voltage for AC:55 V.

#### **Recommended Amperages:**

Size (mm)	I - Range	II - Range
2.50	60 - 70	40 - 50
3.15	85 - 100	55 - 75
4.00	115 - 135	80 - 105

**Tensile Strength:** 69 Kg/mm<sup>2</sup>  
(97,500 psi)