



Pump Casing

Stainless steel electrode specially designed for fertilizer industry

Typical Applications:

Urea processing equipment, chemical plant components.

Outstanding Features:

- Fully austenitic deposit.
- Nil ferrite content.
- Excellent operating characteristics.
- Superior corrosion resistance.

Recommendation:

Electrode combines excellent operating characteristics with a superior weld metallurgy which enables perfect, low-heat input deposition of an alloy with outstanding corrosion resistance such as required for urea service. The weld metal chemistry is very closely controlled to assure total freedom from cracking/fissuring inspite of a fully austenitic metallurgical configuration. Joining/overlay applications on similar or different combinations of AISI 316 L or 316L (modified) Stainless Steels used for

contact parts of urea processing equipment. Also useful for other chemical process plants requiring superior corrosion resistance than that offered by normal 316L grade materials.

Procedure:

Clean weld area. Bevel heavy sections 60° - 90° Vee. Weld with Stringer Beads and short arc. Remove slag between passes. Use staggered weld sequences to balance the heat input.

Recommended Amperages:

Size (mm)	I - Range
2.50	40 - 70
3.15	70 - 100
4.00	80 - 135

Tensile Strength: 56 kg/mm²
(80,000 psi).

Elongation: 40%