



Impeller

Universal electrode for joining of different steel with high strength and corrosion resistance

**Typical Applications:**

Alloy steel pumps, valves, overlaying shafts, joining unknown stainless steel, furnace parts.

**Outstanding Features:**

- Wide range of base metal compatibility.
- Superior weldability.
- Undiluted deposits are non-magnetic.
- Highest chrome-nickel content.

**Recommendation:**

Universal electrode for joining and overlaying all types of steel for high strength with high heat and corrosion resistance. Exceptionally easy to handle, either with a short arc or as a contact electrode. Special Frigid Arc coating permits lowest operating amperages, eliminating distortion and warping. Use as overlay for wear resistance and impact strength. Ideal for most stainless steel, mild, high alloy and special steel. High chrome-nickel content.

**Procedure:**

Clean weld area. Bevel heavy sections 60°-90°. Use a short arc or contact technique. Stringer beads are recommended followed by stress relieving peening on crack-sensitive applications. Intermittent welding may be used, to prevent local heat build-up. Remove slag between multiple passes.

**Recommended Amperages:**

Size (mm)	I - Range	II - Range
2.50	65 - 75	40 - 55
3.15	90 - 110	80 - 90
4.00	120 - 140	100 - 120
5.00	160 - 180	150 - 160

Tensile Strength: 67 kg/mm<sup>2</sup>  
(97,000 psi).