



Special purpose SS electrode for joining a wide variety of SS and MS base materials for high temperature oxidation and heat resistance applications.

Typical Applications:

Anchor welding in Cement & DRI Steel plants, heat exchangers, furnace parts, heat treatment of boxes and baskets, valves, tanks.

Outstanding Features:

- Fully austenitic and exhibit high strength, toughness and Creep resistance.
- Excellent resistance against oxidation and scaling up to 1000°C.
- Ideal for joining of stainless steels of unknown compositions.
- Easy to strike-restrike.
- Finely rippled weld deposit.

Recommendations:

Ideal electrode for joining all types stainless steel, SS to Steel and also for joining applications in steels of relatively high hardenability, clad steels, Chromium-Molybdenum steels etc. Specifically designed for applications requiring high strength and oxidation resistance at elevated temperatures.

Procedure:

Clean weld area, tack at short interval when jigs are not possible. Deposit stringer beads with shortest arc length. Avoid overheating by using intermittent welding sequence. Back-whip craters and remove slag after each pass.

Mechanical Properties (Typical):

Tensile Strength: 63 kg/mm² (90,000 psi)

Elongation: 35%

Recommended Amperages:

Size (mm)	3.15	4.00
I-Range	85-100	115-135
II-Range	55-75	80-105

EWAC Alloys Limited

(A wholly owned subsidiary of Larsen & Toubro Limited)

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