



## A High Strength Electrode for Welding low Alloy High Tensile Steels

### Typical Applications:

Leaf Springs, Hammers, Sow Blocks, Columns, Frames & Structures.

### Outstanding Features:

- High tensile and crack resistance strength.
- Excellent impact resistance.
- No temper embrittlement of weld deposits.
- Strong stable arc with X-ray quality deposits.

### Recommendations:

Joining, built-up and repair of new, worn-out or cracked steel structures, machinery components and other heavy duty equipments. Welding cast steels, fabrication of micro-alloyed and H.S.L.A. steels including automotive applications. Specially suited for repair of forging equipment like columns, sow blocks etc.

### Procedure:

Clean the area. Remove all fatigued or cracked metal. Bevel all edges if required. For heavy sections, pre-heat 250°C-300°C. Weld with short arc gap and electrode tilted 10° in travel direction. Use stringer bead deposition, chip slag between passes and peen weld beads. After completion, retard cooling by covering with sand, asbestos etc. For large assemblies and for forging equipment, stress relieving is recommended.

### Tensile Strength (Typical):

660 MPa (95,000 psi)

### Recommended Amperages:

Size (mm)	3.15	4.00	5.00
Amperages	90-130	120-160	150-190