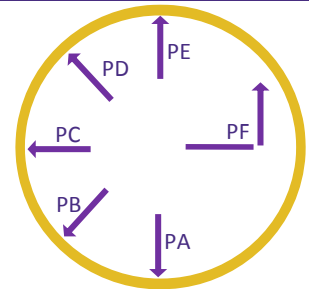


Applications

- Graphite coated electrode with Ni-Fe alloy core rod used for AC/DC in all position welding

Features

- Good crack resistance
- Preheat at 100~200°C (212~392°F)
- Easy to remove slag



Typical Chemical Properties of All-Weld Metal (%)

C	Si	Mn	Ni	Al	S	Cu	Fe
1.48	0.27	1.73	50.2	0.2	0.021	1.3	Bal

Typical Mechanical Properties of All-Weld Metal

Ys MPa	TS MPa	EL (%)	Hardness
387	494	14	90

Diameter mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	300 (14)	350 (18)	350 (18)	350 (18)
F	60-80	80-120	120-150	130-180

Current

AC or DC \pm

Redrying Conditions

300~350°C (572~662°F) X 0.5~1hr

Notes on Usage

- To repair a defect, it must be removed completely by machining or grinding before welding.
- Stringer welding with the maximum bead length 8cm is recommended to prevent overheating, distortion and cracking.
- Backstep, symmetrical or intermittent sequence is recommended for a long welding line to prevent cracking.

Packing Details

2Kg Pack / 10 Kg Ctn (Vacuum Packing)