

## Covered Electrodes

# TENSILE WELD

For stainless steel (Cladding or Dissimilar joint)

### Description

- Covering is lime titania type for welding of 29%Cr-9%Ni type cast steels and difficult to weld steels. Joint welding and hardfacing of stainless steel and heat resisting steels.
- Good crack resistance because of extremely much quantity of ferrite of the deposited weld metal.
- Good usability and weldability.
- Redry the electrode at 250-350°C for 30-60 minutes prior to use.

### Welding positions



### Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo	Cu
0.08	0.95	1.48	0.032	0.015	8.65	29.83	0.13	0.09

### Typical mechanical properties of all-weld metal

	Y.S (0.2%OS) (MPa)	T.S (MPa)	El. (%)	Remarks
Typical Values	520	770	24	AW

\* AW : As-Welded

### Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	300	350	350	350
Amp. (A)	F V · OH	40-80 35-75	70-110 70-100	110-140 90-130	140-180 -