

CATEGORY SMAW Stick Electrodes

TYPE Special alloy for welding unknown and difficult to weld steels.

APPLICATIONS This austenitic-ferritic special alloy is suitable for joining steels that are difficult to weld. Varied application in repair and maintenance of machines, shafts, gearwheels, especially in the field of building machinery. Also excellent for buffer layers before Hardfacing and for dissimilar welding between steel, stainless steels or unknown steels.

PROPERTIES Very popular because of its soft, stable arc, its easy spatter free application and the very good slag removal with no residues. High corrosion resistance and high temperature resistance up to 1100 °C. with excellent weldability on both AC and DC+.

CLASSIFICATION	AWS	A 5.4: E 312
	EN ISO	3581-A: E 29 9 R 12
	F-nr	5
	FM	5
	W.Nr.	1.4337

SUITABLE FOR Manganese steel, spring steel, high speed tool steels, Hss, C45, C60, dissimilar welding, maintenance, buffer layers, repairing cock wheels, 42MnV7, 25CrMo4, 42CrMo4, 50CrMo4, 1.5223, 1.7218, 1.7225, 1.7228, stainless steel, difficult to Weld steel, unknown steel,

APPROVALS CE

WELDING POSITIONS:



TYPICAL WELD DEPOSIT WEIGHT %

C	Si	Mn	P	S	Cr	Ni
0.1	0.8	1.5	0.02	0.015	30	9

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R <sub>p0.2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Impact Energy (J) ISO-V RT	Hardness Brinell Hardness
As Welded /	500	750	23	40	Avg. 300

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING	PACKING
D (MM)	LENGTH (MM)	CURRENT (A)	KG / PARCEL	KG / 6PACK	KG / 1000
1.6	275	40-60	2.0	12	
2.0	300	50-70	2.4	14.4	
2.5	350	70-90	2.4	14.4	
3.2	350	90-130	2.5	15	
4.0	450	120-180	2.5	15	
5.0	450	170-220	2.5	15	

REDRYING TEMPERATURE 300°C / 2 hr

GAS ACCORDING EN 14175