



ARMINOX

STAINLESS STEEL (Heat Resisting)



Stainless Steel Welding Electrode for armour Steel Welding

KEY FEATURES :

- A medium-Heavy coated electrode
- Austenitic stainless steel weld deposit
- Smooth and stable arc
- All position welding
- Radiographic quality weld

WELDING POSITION :



AC (70 OCV) / DCEP

TYPICAL APPLICATIONS :

- Welding different grades of armour steels, stainless steels with carbon steel
- For depositing austenitic weld metal on high carbon steels

REDRYING CONDITION : 250-300°C for minimum 1 hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

| | C | Mn | Si | Cr | Ni | Mo | S | P |
|---------------|----------|-----------|-----------|-----------|-----------|-----------|----------|----------|
| Specification | 0.10 max | 0.80-2.0 | 0.40-0.90 | 18.0-21.0 | 8.50-10.0 | 2.30-2.90 | 0.03 max | 0.03 max |

MECHANICAL PROPERTIES OF ALL WELD METAL :

| | Condition | UTS, MPa | EL% |
|---------------|------------------|-----------------|------------|
| Specification | As Welded | 690-880 | 25-35 |

PARAMETERS - PACKING DATA :

| Ø x L, mm | Amperage, A | Wt./Carton, Kg | Cartons/Box | Net wt./Box, Kg |
|------------------|--------------------|-----------------------|--------------------|------------------------|
| 2.0 x 300 | 50-80 | 2 | 5 | 10 |
| 2.5 x 350 | 80-110 | 2 | 5 | 10 |
| 3.15 x 350 | 110-160 | 2 | 5 | 10 |
| 4.0 x 350 | 160-200 | 2 | 5 | 10 |