



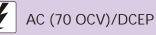
Special Electrode for urea reactors and chemical industries

KEY FEATURES :

- Rutile coated electrode
- Extra low carbon 17/13/5Mn/Mo type fully austenitic weld deposit
- Nearly zero ferrite content

WELDING POSITION :

- Excellent corrosion resistance at high temperature service
- Smooth operating characteristics Radiographic quality weld



TYPICAL APPLICATIONS :

- Specially designed for Urea reactors and Chemical industries
- Welding of Mo bearing austenitic alloys such as AISI 316, 316L, 317, 317L, 318 types
- Suitable for material no. 1.4401, 1.4404, 1.4406, 1.4408, 1.4429, 1.4435, 1.4436, 1.4437, 1.4571, 1.4580, 1.4583

REDRYING CONDITION 300°C for 1 hr. (Also available in vacuum packed condition)

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :								
	С	Mn	Si	Cr	Ni	Мо	S	Р
Specification	0.04 max	5.0-7.0	0.30-0.80	17.0-18.5	11.0-14.0	2.0-3.0	0.03 max	0.03 max

MECHANICAL PROPERTIES OF ALL WELD METAL :						
	Condition	UTS, MPa	EL%	Ferrite No.		
Specification	As Welded	550-650	35-45	0.5 max		

PARAMETERS - PACKING DATA :						
Ø x L, mm	Amperage, A	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg		
2.5 x 300	50-75	2	5	10		
3.15 x 300	80-100	2	5	10		
4.0 x 300	110-140	2	5	10		
5.0 x 300	150-180	2	5	10		

Special batches with modified chemistry to suit customer specifications are available.