

High strength – soft arc**GENERAL DESCRIPTION**

Exceptional mechanical characteristics.
 Recommended for all steels that are difficult to weld.
 Highly alloyed with Ni, Cr and Mn.
 The deposited material is very tough, crack-free, and has an exceptional resistance to shocks and fatigue.
 Good resistance to wear, corrosion and heat.
 Very soft arc, with minimum spatter and no undercut.

APPLICATIONS

Wear plates for waste disposal, teeth of dredger buckets.
 Repair of cracked buckets and scoops.
 Repair of tractor-platforms, rear axle and fellies of trucks, leaf springs, broken crank shafts.
 Base layer for surfacing on problem steels.
 Repair of broken cutting tools.
 Wear-resistant surfacing of machine parts e.g. plastic injection moulds.

Hardness: 220 HB

CHEMICAL COMPOSITION (%) (Typical values, all weld metal)

C : 0.10	Cr : 28.00	Mo : 0.25	Mn : 1.00	Si : 1.50
Ni : 12.00	Fe : Balance			

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
	890 MPa	≥ 28 %	

GENERAL INFORMATION

Welding positions	All, except vertical down				
Shielding gas	NA				
Packing	5 Kg in a plastic box				
Polarity	Ac or DC, reverse polarity (electrode positive)				
Diameter (mm)	1.5	2.0	2.5	3.2	4.0
Length (mm)	250	250	275	300	350
Approx. current (A)	15 - 35	20 - 50	30 - 65	45 - 125	80 - 160

Tips & Tricks

Use a short arc, electrode position almost 90° to the workpiece.
 Allow each weld bead to cool slightly before making a further deposit.
 For welding on crack sensitive steels, pre-heat the work piece until it reaches the tempering temperature of the steel.
 Avoid rapid cooling.
 12-14% Manganese steel is always welded cold (max 350 ° C).