

## UNIVERSAL ELECTRODE FOR HEAT AND CORROSION RESISTANT WELDS IN ALMOST ALL KINDS OF STAINLESS AND MILD STEEL, IN HIGH ALLOY STEEL AND IN SPECIAL STEEL

CLASSIFICATION A.W.S: N / A

IDENTIFICATION: WHITE COATING. RED TIP

**APPLICATIONS:** To weld stainless steel, high alloy steel and other stainless type steel whose composition is unknown. Some typical applications are oven parts, mild steel, chemical industry equipment, furnace parts which have to withstand temperatures of up to 1200°C. Manufacture and repair of mining and railroad equipment in cold climate areas

**CHARACTERISTICS AND PROCEDURE:** This electrode provides top mechanical resistance together with its corrosion and wear resistance. It has been widely used to weld low alloy steel when pre-heating or heat treatment is not feasible..

252 welding rod can be used in all sectors of industry; it can be used not only in maintenance but also in manufacturing as a multipurpose welding rod to weld carbon steel and alloy steel. Parts to be welded should be carefully cleaned. Whenever the part is large, preheat it up to 200°C. Use a short arc to prevent the welding rod from sticking or choking into the weld pool. Best results are obtained when using enough amperage so as to attain good fusion. Avoid too much weaving. A series of straight weld seams is preferable. In vertical and overhead welding, set AMP as low as possible.

<b>TENSILE RESISTANCE:</b>	6,680 KG./CM <sup>2</sup> (95,000 PSI)
<b>BRINELL HARDNESS:</b>	200 BHN
<b>ELONGATION:</b> :	30%
<b>FERRITE No.:</b>	N/A.
<b>POSITIONS:</b>	ALL
<b>CURRENT:</b>	AC or DC REVERSE POLARITY

FILLER METAL CHEMICAL ANALYSIS %	SIZES	AMPERAGE
NOT APPLICABLE	2.28 mm - 3/32"	50-70
	3.25 mm - 1/8"	80-100
	4.0 mm - 5/32"	110-130
	5.0 mm - 3/16"	140-170