275

HIGH RESISTANCE WELDING ROD FOR ALLOY AND CARBON STEEL. ITS FILLER METAL IS HIGHLY RESISTANT TO TENSION AND HIGHLY ELASTIC.

CLASSIFICATION A.W.S: N / A

IDENTIFICATION: BLUE COATING

APPLICATIONS: It is used when friction and impact resistant welds are necessary. It provides the right solution for steel which requires cladding with the best possible properties. It is used whenever a high quality weld is required in pressure vessels, sea water pipelines, templates, tools and similar parts. It is also used with nickel clad steel, in vanadium molybdenum steel leave springs and in medium carbon steel. It is ideal to be used as a buffer before the application of layers of chemical coatings and to clad shafts. It is generally used with different kinds of steel and for those jobs where the highest possible tension resistance is required.

CHARACTERISTICS AND PROCEDURE: The resulting filler metal from this welding rod is very elastic, it has high mechanical resistance and a very nice look. It can be highly polished and has no pittings or splatter. It is easily machined. The metal deposit is achieved at the highest possible rate with the lowest possible heat on the base metal and using the lowest possible amperage. Clean the area to be welded carefully and follow the normal routine to prepare the joint. Chamfer the heavier sectors to achieve total penetration. For tool steel with high alloys, it is recommended to preheat up to 200°C. When using DC, use reverse polarity. Keep the arc short. Make rows of weld beads. Intermitent welding can be used, specially in high alloy steel. Allow each weld seam to cool down before removing the slag. Hammering will help anneal the part. Slag removal is quite easy.

TENSILE RESISTANCE:	8,450 KG./CM2 (120,000 PSI)
BRINELL HARDNESS:	235BHN (RC-23)
ELONGATION:	25%
POSITIONS:	ALL
CURRENT:	DC REVERSE POLARITY and AC
FILLER METAL: :	MAGNETIC

FILLER METAL CHEMICAL ANALYSIS %	SIZES	AMPERAGE
NOT APPLICABLE	2.38 mm - 3/32"	50-70
	3.25 MM - 1/8"	75-110
	4.0 mm - 5/32"	100-130
	5.0 mm - 3/16"	130-180