

COVERED ELECTRODES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SS-385 is an austenitic structure and the weld metal contains 20%Cr-25%Ni-4.7%Mo-1.5%Cu.
- It possesses the advantage of high corrosion capability against sulfuric acid, and phosphoric acid.
- It is suitable for the use of the steels loading with sulfuric acid and chloride media as ASTM B625 and B673.

NOTE ON USAGE :

- Re bake the electrodes at 250 ~ 300°C for 1 hour and keep it at 100~150°C prior to use.
- With lower current is to properly keep the dilution of the parent metal for welding crack.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Ni	Cr	Mo	Cu
0.030	1.62	0.49	0.025	0.002	24.80	20.70	4.35	1.35

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %
600(61.2)	40

SIZE AND RECOMMENDED CURRENT RANGE : AC or DC(+)

Diameter (mm)		2.6	3.2	4.0	5.0
Length (mm)		300	350	350	350
Current (Amp)	F	50-85	80-120	100-150	140-180
	V & OH	45-80	70-110	90-135	-