

COVERED ELECTRODES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SS-430 is a titanium oxide low hydrogen electrode, the weld metal contains 17%Cr the ferritic structure.
- Advantage of corrosion resistance, better heat conductivity to the austenitic structure, and the smaller CTE (Coefficient of thermal expansion).
- It is suitable for SUS 430 and the parts of heavy oil burner.

NOTE ON USAGE :

- Rebake 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.
- Preheat at 200 ~ 400°C before welding, and the PWHT at 760 ~ 790°C for 2 hours and finally, to naturally cool down to 595°C.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Ni	Cr
0.040	0.826	0.64	0.030	0.005	0.20	17.20

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %	HEAT TREATMENT
540(55.1)	22	780°Cx2hr

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	60-85	80-120	100-150	140-170
	V & OH	60-80	65-105	95-140	-