

COVERED ELECTRODES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SS-307HM is a titanium oxide low hydrogen electrode, the weld metal contains 18%Cr-8%Ni-6%Mn the full austenitic structure.
- It is suitable for clad stainless steel, high tensile steel, steels difficult to weld, nuclear submarine, and armor plate at a non-magnetic site.

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.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Ni	Cr
0.098	5.5	0.45	0.029	0.010	8.8	19.7

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %
615(62.8)	39

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	140-170
	V & OH	45-80	70-110	90-135	-