



# X-105

## SPECIAL ELECTRODE

### For Welding Galvanizing Bath & Kettle

#### DESCRIPTION

X-105 is a special purpose electrode specially designed for welding hot -dip galvanizing baths. The weld metal is highly resistant to molten zinc corrosion. Electrode is further characterized by soft arc, easily detachable slag and low spatter.

#### APPLICATIONS

Typical application include welding galvanizing baths, filling up of worn-out body of galvanizing bath to resist molten zinc corrosion, window frames, thin walled tanks and vessels etc.

#### CHEMICAL COMPOSITION %

C	Mn	Si	S	P
0.05 max	0.25 max	0.05 max	0.035 max	0.035 max

#### ALL WELD MECHANICAL PROPERTIES

UTS, MPa	Elongation %
414	32

#### RECOMMENDED CURRENT CHARACTERISTICS : AC/DC (-)

SIZE mm DXL	3.15x450	4.00x450	5.00x450
CURRENT (Amps)	110-135	160-180	200-240

#### PRECAUTIONS

Rebake the moist electrodes at 200-250°c for one hour before use. Use short arc during welding.

Packing Specification – Supplied in 5 kgs x 4 Pkts = 20 Kgs