



NEXA-1106

**AUSTENO -FERRITIC STAINLESS STEEL
ELECTRODE FOR HIGH STRENGTH AND
CRACK- RESISTANT WELDS.**

ALLOY BASE : Fe, Cr, Ni.

SPECIAL FEATURES

- Gives Austeno- ferritic crack resistance weld.
- Deal for welding unidentified steels.
- Gives smooth weld, with uniform ripples, with no slag interference.
- Deposit extremely tough.

APPLICATIONS

Most suitable for joining armour steel, Aust. Manganese steel, cast steel, forged steel and stainless steel to carbon steel of unknown composition. Surface of grooved rolls and the repair of dropped forge dies. As a cushioning layer before hard facing.

TECHNICAL DATA

UTS	:	70-77 kgf/mm ²
Elongation(L=4d)	:	30-32%
Hardness of pure weld metal	:	180-220 Brinell.

CURRENT RANGE : DC (+)

SIZE mm	3.15	4.00	5.00
CURRENT (Amps)	80-130	110-140	150-155