



NEXA-360

AUSTENITIC ACID-RESISTANT ELECTRODE.

ALLOY BASE : Fe , Cr, Ni, Mn.

SPECIAL FEATURES

- Resists pitting due to acids and highly concentrated chemicals.
- Requires low amperage, so as to avoid warpage.
- Deposition is rapid and smooth.
- Suitable for highly restrained joints.
- Moly bearing SS welding alloy.
- Suitable for AISI 316, 316L , and 318 stainless steels.
- Minimised carbide precipitation.

RECOMMENDATIONS

Recommended for AISI 316, 316L, 317 and 318 type stainless steels for higher resistance to corrosion, heat resistance up to 300°C. Resistance to impact, corrosion, heat and scaling is excellent. Protective overlay on steel for medium hardness and high corrosion resistance.

APPLICATIONS

Steam turbine blades, mixers chemicals pumps plating tank, hot forging dies, paper industries . Digesters and other fertilizers plant application

PROCEDURES

Clean weld area . use clamps or holding devices to avoid the distortion. Track weld at short gaps and use short arc. Use skip technique. Avoid use of weaving and chip out slag between passes.

TECHNICAL DATA

Tensile Strength : 55-65 kgf / mm²
Elongation : 30 – 40 %

CURRENT RANGE : DC (+)

SIZE mm	2.50	3.15	4.00
CURRENT (Amps)	50-75	80-110	120-140