



# NEXA-BL

## AUSTENITIC STAINLESS STEEL ELECTRODE.

**ALLOY BASE** : Fe , Cr, Ni.

### SPECIAL FEATURES

- Easy Arc striking.
- Radiographic quality welds metal.
- Extra low carbon content.
- Suitable to resist heat corrosion and carbon precipitation.
- All positional.
- Exceptional weldability.
- Superior colour match.

### RECOMMENDATIONS

Recommended for AISI 301,302,304,304L,308L type stainless steel. Suitable for welding parts used in severe corrosive condition. Welding at low amperage especially recommended for joining extra low carbon grades to minimize carbide precipitations and avoids strongly intergranular corrosion. Superior resistance to impact, heat and scaling.

### APPLICATIONS

Kitchen equipments, milk dairy equipment, mixer refineries, brewery, chemical industries, containers, mixer & nuclear plants.

### PROCEDURES

Clean weld area. Use jigs/back up plates for clamping or tack at short gaps to decrease distortion. Use short arc, stringer beads and number of light bead. Avoid weaving and chip out slag between passes.

### TECHNICAL DATA

Tensile Strength : 53-65 kgf / mm<sup>2</sup>

Elongation : 35 – 40 %

### CURRENT RANGE : DC (+)

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