



# NEXA-670H

## ELECTRODE FOR HK 30, HK 40 AND SIMILAR HEAT-RESISTANT ALLOYS

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

### SPECIAL FEATURES

- Easy arc striking.
- Easy slag removal.
- Evenly rippled shining bead.
- The weld deposit can withstand temperatures up to 1150°C in continuous service.
- Use low current and short arc.

### APPLICATIONS

For welding reformer tubes (also called furnace tubes) made of HK 30 and HK 40 alloys used in fertilizer industries, oil refineries, petrochemical plants, etc.

### PROCEDURES

Before welding, dry the electrode at 250-300°C for 2 hours. It is advantageous to use a stringer bead with short arc.

### TECHNICAL DATA

Tensile Strength : 62 kgf / mm<sup>2</sup>

### CURRENT RANGE : DC (+)

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