



NEXA-390

SUPERIOR WELDING ALLOY FOR HIGH RESISTANCE TO HEAT AND CORROSION

ALLOY BASE : Cr, Ni, Fe

SPECIAL FEATURES

An extra low carbon, all position electrodes. Gives stable arc, low spatter, smooth weld profile, easily removable slag. The weld deposit is of radiographic quality and withstand temp. upto 1200°C.

RECOMMENDATIONS

Ideal for welding of AISI 309, stainless steel of unknown composition and stainless steel to mild steel. Designed for application requiring a high degree of oxidation resistance and high strength.

APPLICATIONS

Suitable for welding of AISI 309, stainless steel of unknown composition and stainless steel to mild steel etc.

PROCEDURES

Clean weld area of any surface contamination and stringer beads, intermittent welding may be used to avoid heat buildup. Preheat is not necessary.

TECHNICAL DATA

Tensile Strength : 65-75 kgf / mm²
Elongation : 25 – 30 %

CURRENT RANGE : DC (+)

SIZE mm	2.15	3.15	4.00
CURRENT (Amps)	50-75	60-110	90-130