



NEXA-660

ELECTRODE FOR MEDIUM-TENSILE DUCTILE STEEL WELDS

ALLOY BASE : C, Mn, Si

SPECIAL FEATURES

- Crack free deposits with higher strength.
- Ideal for contaminated surfaces
- Highly ductile
- It gives radiographic weld bead.
- Excellent impact resistance.

RECOMMENDATIONS

Low alloy sheets, low carbon steels, medium carbon steels, problem steels having sulphur contents, high tensile steel. Very much useful where toughness and weld reliability are important.

APPLICATIONS

Flanges, sulphur and phosphorous steel, heavy equipment maintenance, automobile chassis, tanks, pressure vessels.

PROCEDURES

Clean the area to be welded. Use short arc, on DC power source with reverse polarity. It is recommended to dry the electrode at 300°C for one hour before use.

TECHNICAL DATA

Tensile Strength	:	55-55 kgf / mm ²
Elongation	:	26 – 30 %

CURRENT RANGE : DC (+)

SIZE mm	3.15	4.00	5.00
CURRENT (Amps)	90-140	140-180	180-250