



NEXA-106

ELECTRODE FOR HIGH STRENGTH AND EXTREME CRACK RESISTANCE

ALLOY BASE : Fe , Cr, Ni, Mn.

SPECIAL FEATURES

- Controlled grain structure for high strength and for ductility.
- Controlled ferrite-austenite duplex structure.
- Low amperage, extremely low spatter, easy strike and re- strike.
- Weld bead is smooth, tough with superior crack resistance.
- Optimum resistance to friction, heat, corrosion impact.

RECOMMENDATIONS

A versatile electrode for welding most type of steels. Very high tensile strength and highly suitable for the welding of dissimilar and unknown steels. It is suitable for combination of similar and dissimilar steel and joining steels of different thicknesses.

APPLICATIONS

Tools dies, pinions, springs, shafts, machinable build up and overlays, automobile application including gear box main shaft, counter shaft and key ways. Joining of wear plates, buckets, many more application in sugar industries.

PROCEDURES

Clean the joint area thoroughly and prepare joint edges. Preheat high alloy and high carbon steel to about 200-250°C followed by slow cooling after welding. Use short arc with stringer bead technique.

TECHNICAL DATA

Tensile Strength : 85 kgf / mm²
Elongation : 22 – 24 %

CURRENT RANGE : DC (+)

SIZE mm	2.50	3.15	4.00
CURRENT (Amps)	50-75	70-110	110-140