



NEXA-680

AUSTENITIC-FERRITE ELECTRODE WITH EXCELLENT DUCTILITY AND HIGH TENSILE STRENGTH.

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

Weld deposit gives superior crack resistant, suitable for all types of steels including austenitic Mn steel and die steels. Optimum resistance to heat, impact and corrosion etc.

APPLICATIONS

For joining dissimilar steels of unknown composition, and welding of springs steel etc. For depositing cushioning layer on difficult to weld steel before depositing final surfacing layer.

PROCEDURES

Clean the joint area thoroughly. Use DCRP (DC+) on DC power source. Stringer bead technique should be preferably used with a short arc. Prepare X, V or U groove on thick-walled work piece with an angle of 60-80°C. preheat high carbon containing steel to approx. 250°C. while weaving restrict upto 2-3 times electrode diameter.

TECHNICAL DATA

Tensile Strength : 80-85 kgf / mm²
Elongation : 22 – 24 %

CURRENT RANGE : DC (+)

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