



NEXA-008

AUSTENITIC STAINLESS STEEL ELECTRODE.

ALLOY BASE : Fe, Cr, Ni,

SPECIAL FEATURES

- Self-releasing slag with little or no need for weld dressing or fettling negligible spatter.
- High quality weld deposit with defect free radiographic performance in multi pass welds.
- Extra low carbon content.
- Suitable to resist heat corrosion and carbon precipitation.
- All positional.
- Exceptional weld ability

RECOMMENDATIONS

Recommended for AISI ,302,304,304L,308L type stainless steel. Suitable for welding parts used in severe corrosive condition. Welding at low amperage especially recommended for joining extra low carbon grades to minimize carbide precipitations and avoids strongly intergranular corrosion. Superior resistance to impact, heat and scaling.

APPLICATIONS

Kitchen equipment's, milk dairy equipment, mixer refineries, brewery, chemical industries, containers, mixer & nuclear plants.

PROCEDURES

Clean weld area. Use jigs/back up plates for clamping or tack at short gaps to decrease distortion. Use short arc, stringer beads and number of light bead. Avoid weaving and chip out slag between passes.

TECHNICAL DATA

Tensile Strength : 53-65 kgf / mm²
Elongation : 35-40 %

CURRENT RANGE : DC (+)

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