



NEXA-670

FULLY AUSTENITIC HEAT RESISTANT ALLOY ELECTRODE

ALLOY BASE : Fe , Cr, Ni,

SPECIAL FEATURES

- A unique all positional austenitic stainless steel welding alloy for AISI 309 & 310 stainless steel.
- Ideal for high oxidation resistance maintain high strength at temperatures up to 1200°C.
- Suitable for stainless steel of unknown analysis.

APPLICATIONS

Suitable for welding of steel with high carbon content often used in the building field . furnace lining , furnace parts , burners heat treatment pots and baskets.

PROCEDURES

Clean weld area of oil , grease or any dirt carefully. If jigs are not available for clamping the work must to tack welded. Weld a number of light beads maintaining short arc. To avoid over heating intermittent welding may be used. Frequently clean the slage between passes.

TECHNICAL DATA

Tensile Strength : 55-65 kgf / mm²
Elongation : 30-35%

CURRENT RANGE : DC (+)

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