WELDALL

45 OCV | AC DC+

- Easy-to-Use Rutile Type, High Alloy Electrode.
- Outstanding Operator Appeal!
- WELDS ALL Steels!
- Ideal for Repair & Maintenance Jobs.
- Easy ARC Starting and Excellent Stability on Low O.C.V Welding Machines.
- Not Recommended for Welding Cast Irons.
- Packed in Resealable Plastic Tubes.

TYPICAL ALL WELD METAL ANALYSIS:

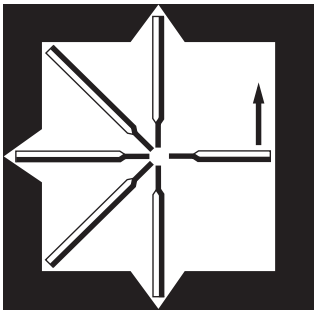
C: 0.11%	Mn: 0.60%	Si: 0.88%
Cr: 28.4%	Ni: 9.10%	S: 0.011%
P: 0.020%		

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

0.2% Proof Stress	630 MPa
Tensile Strength	780 MPa
Elongation	25%
CVN Impact Values	30 J av @ +20°C.

Classifications:

ISO AS/NZS 4854:	B ES312-17
AWS/ASME-SFA A5.4:	E312-17



All positional - except vertical down

Description and Applications:

WELDALL is a highly alloyed stainless steel electrode which deposits a strong and ductile duplex austenite-ferrite weld metal extremely resistant to cracking.

WELDALL has a host of features which make it suitable for the welding of all types of steels. These include;

- Easy arc starting and excellent stability on low Open Circuit Voltage (O.C.V) welding machines such as the CIGWELD Easywelder EC.
- Rutile type flux coating gives smooth, stable running in all positions (except vertical down) especially on low current settings.
- High ferrite (≈ 40%) austenitic stainless steel deposit gives excellent resistance to hot cracking, even when diluted with carbon, austenitic and high alloy steels.
- Weld deposit gives excellent resistance to corrosion and oxidation.

WELDALL is recommended for the repair and maintenance of all steels, particularly those of unknown composition. It is suitable for;

- Joining dissimilar steels, such as stainless steel to carbon steel.
- Repairing die or tool steels.
- Use as a protective overlay against corrosion.
- Use as an intermediate or buffer layer prior to hard surfacing.

Packaging and Operating Data:

AC (minimum 45 O.C.V.), DC+ polarity.

Electrode Size mm	Electrode Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
2.5	300	49	50–85	1.6kg	9.6kg – 6 x 1.6kg	611702N
3.2	350	27	60–125	1.8kg	10.8kg – 6 x 1.8kg	611703N
4.0	350	16	80–175	4.4kg	13.2kg – 3 x 4.4kg	611704N